

METHOD OF FORMING GLOSSY IMAGE

FIELD OF THE INVENTION

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This invention relates to a method of forming a full color image with high resolution by laser thermal transfer recording. More particularly, it relates to an image forming method useful to obtain direct digital color proofs (DDCP) in the field of printing or mask images according to digital image information.

BACKGROUND OF THE INVENTION

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In the field of graphic arts, a printing plate is produced using a set of color separations of a color original prepared using lithographic films. In general, color proofs are prepared from color separations in order to inspect for errors in color separation and to check the need for color correction and the like before printing. Color proofs are required to realize high resolution enabling accurate half tone reproduction and high processing stability. To obtain color proofs close to actual prints, it is desirable for the materials of color proofs to be the same as those used on press, i.e., the same paper and the same pigments. There is a higher demand for a dry process

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involving no processing solutions for the preparation of color proofs.

With the recent spread of computerized systems in prepress work, recording systems for preparing color proofs directly from digital signals have been developed. Such computerized systems, particularly contemplated for preparing high quality color proofs, are generally capable of reproducing dot images at 150 lines or more per inch. In order to obtain high quality proofs from digital signals, a laser beam is used as a recording head, which is capable of modulation according to digital signals and focusing into a small spot diameter. Hence it is demanded to develop image forming elements that exhibit high sensitivity to laser light and high resolution enabling reproduction of highly precise dot images.

Image forming elements known useful in laser transfer methods include a thermal melt transfer sheet, which comprises a substrate, a light-heat conversion layer capable of absorbing laser light to generate heat, and an image forming layer having a pigment dispersed in a heat fusible matrix (e.g., a wax or a binder) in the order described, as disclosed in JP-A-5-58045. A thermal transfer sheet of this type is brought into contact with an image receiving sheet and imagewise irradiated with a laser beam. The irradiated area of the light-heat conversion layer generates heat to melt the image forming layer, and the molten part of the image forming layer is transferred to the

image receiving sheet.

JP-A-6-219052 teaches a thermal transfer sheet comprising a substrate, a light-heat conversion layer containing a light-heat converting substance, a release layer as thin as 0.03 to 0.3 μ m, and an image forming layer containing a colorant. According to this technique, the release layer reduces its bonding strength between the image forming layer and the light-heat conversion layer upon being irradiated with laser light. As a result, the image forming layer is allowed to be transferred to an image receiving sheet that has been brought into contact with the thermal transfer sheet to form a high precision transfer image. This image formation method utilizes laser ablation. That is, a laser-irradiated part of the release layer decomposes and vaporizes, resulting in reduction of the strength bonding the image forming layer and the light-heat conversion layer in that area. As a result, the image forming layer of that area is transferred to the image receiving sheet.

These imaging methods are advantageous in that images can be formed on printing paper having an image receiving layer (adhesive layer) and that a multicolor image can easily be obtained by successively transferring images of different colors onto the same image receiving sheet. The method utilizing ablation is particularly advantageous for ease of forming a highly precise image and is useful to prepare color proofs (DDCP) or precise mask images.

With the spread of desk-top publishing (DPT) work, printing companies adopting a computer-to-plate (CTP) system have a strong demand for a DDCP system, which eliminates the need of intermediate film or plate output as has been involved in traditional analog proofing. In recent years, DDCPs with higher quality, higher stability, and larger sizes have been demanded as good approximations to the final prints.

Laser thermal transfer systems are capable of printing at high resolution. Options include laser sublimation, laser ablation, and laser melt, each of which has the problem that the recorded dot shape is not sharp enough. The laser sublimation system is insufficient in approximation in color to the final print result because of use of dyes as coloring matter. Besides, this system involving dye sublimation results in blurred dot outlines, failing to achieve sufficiently high resolution. The laser ablation system, which uses pigments as coloring matter, provides a satisfactory approximation in color to the final printed products, but the dots are blurred, resulting in insufficient resolution similarly to the dye sublimation system because of the involvement of coloring matter scattering. The laser melt system also fails to create clear dot outlines because the molten colorant flows.

The colors that can be reproduced by conventional heat transfer sheets are limited to process colors (i.e., yellow, magenta, cyan, and black) and their combinations. There are

needs for metallic spot colors that are difficult to reproduce with the four process colors, such as metallic gold and metallic silver. While it is known that these metallic colors can be reproduced by using tabular inorganic particles, there is still
5 room for improvement in sensitivity and resolution.

SUMMARY OF THE INVENTION

10 An object of the present invention is to provide a method of forming a glossy image with a variety of metallic luster excellent in performance stability, sensitivity and resolution by use of laser thermal transfer recording elements.

Another object of the invention is to provide a method
15 of stably forming a high quality and large size DDCP serving as a good approximation to final printed products.

Still another object of the invention is to provide a glossy image forming method which provides a high quality image with a constant density on an image receiving sheet even when
20 high-energy multibeam of laser light are used for heat transfer recording under different temperature and humidity conditions.

The present invention provides a method for forming a glossy image comprising

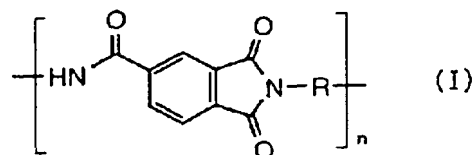
using (A) a heat transfer sheet comprising a substrate
25 having thereon a light-heat conversion layer and an image forming

layer provided in this order wherein the light-heat conversion layer contains a polyamide-imide resin, and the image forming layer contains at least one of tabular inorganic compound particles and metal particles and a thixotropic agent, (B) a
5 heat transfer sheet comprising a substrate having thereon a light-heat conversion layer and an image forming layer provided in this order wherein the light-heat conversion layer contains a polyamide-imide resin, and the image forming layer contains a transparent colorant, and (C) an image receiving sheet having
10 an image receiving layer and

imagewise transferring the image forming layer of each of the heat transfer sheet (A) and the heat transfer sheet (B) to the image receiving layer by laser heat transfer.

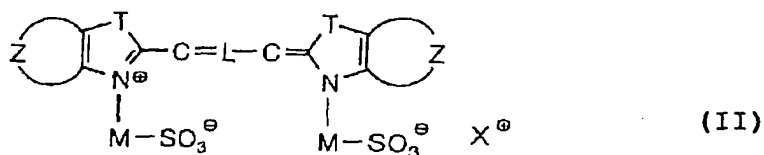
The present invention provides preferred embodiments of
15 the image forming method, in which:

(1) The polyamide-imide resin is represented by formula (I):



wherein R represents a divalent linking group; and n represents an integer of 10 to 100.

(2) The light-heat conversion layer contains, as a light-heat
25 converting substance, a dye represented by formula (II):



wherein Z represents an atomic group necessary to form a benzene ring, a naphthalene ring or a heterocyclic aromatic ring; T represents -O-, -S-, -Se-, -N(R¹)-, -C(R²)(R³)- or -C(R⁴)=C(R⁵)-; R¹, R², and R³ each represent an alkyl group, an alkenyl group or an aryl group; R⁴ and R⁵ each represent a hydrogen atom, a halogen atom, an alkyl group, an aryl group, an alkoxy group, an aryloxy group, a carboxyl group, an acyl group, an acylamino group, a carbamoyl group, a sulfamoyl group or a sulfonamido group; L represents a trivalent linking group consisting of 5 or 7 conjugated methine groups; M represents a divalent linking group; and X⁺ represents a cation.

(3) The light-heat conversion layer has a light absorbance of 70 to 95% when irradiated with laser light.

(4) The laser light used in the laser heat transfer is from a plurality of arrayed semiconductor lasers each having an output power of 0.5 W or higher.

(5) The image receiving sheet has a cushioning layer.

(6) The surface roughness of the image receiving layer of the image receiving sheet is such that a smoother value is 5 mmHg or smaller and a center-line average roughness Ra of 0.04 to

0.3 μm .

(7) The metallic particles are particles of at least one metal selected from the group consisting of aluminum, gold, silver, copper, and zinc.

5 (8) The tabular inorganic compound is a pearl pigment.

(9) The pearl pigment is mica powder.

(10) The thixotropic agent is a fatty acid amide and/or polyethylene oxide.

10 (11) The method further comprises re-transferring the image forming layers transferred to the image receiving layer to a sheet of printing paper.

BRIEF DESCRIPTION OF THE DRAWING

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Fig. 1 (Figs 1A to 1D) shows a scheme for forming a multicolor image by thin film thermal transfer by laser beam.

Fig. 2 shows a configuration of a laser thermal transfer recording apparatus.

20 Fig. 3 shows a configuration of a thermal transfer apparatus.

Fig. 4 shows a system configuration including laser thermal transfer recording apparatus FINALPROOF.

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DETAILED DESCRIPTION OF THE INVENTION

The present inventors previously studied to provide digital proofs of B2/A2 or larger sizes and even of B1/A1 or larger sizes while retaining high image quality, high quality stability, and satisfactory approximation to an actual finished level. As a result, they developed a laser thermal transfer recording system for DDCP, which uses (a) an image forming element characterized by capability of image transfer to the same paper as printing paper, capability of outputting true halftone dot, use of pigments as a colorant, and large sizes of B2 or larger and (b) an output device combined with (c) high quality content management system (CMS) software. The laser thermal transfer recording system developed by the inventors is featured by (1) sharp dot formation, which offers a good approximation to final prints, (2) a satisfactory hue approximation to final prints, and (3) stable proof quality owing to performance stability against variations of the environment (i.e., temperature and humidity) and repetition.

From the aspect of material design, technical key points that allow this system to be developed are establishment of thin film transfer technology and improvements on the heat transfer elements' capability of being tightly held on a recording drum by suction, capability of high-resolution recording, and heat resistance. More specifically, the

developed thermal transfer recording system has been realized by (i) introduction of an infrared absorbing colorant, which allows a light-heat conversion layer to be reduced in thickness, (ii) introduction of a high-Tg polymer, which enhances heat resistance of a light-heat conversion layer, (iii) introduction of a heat-resistant pigment, which leads to hue stabilization, (iv) addition of a low-molecular component, such as a wax and an inorganic pigment, which controls adhesion and cohesion, and (v) addition of a matting agent to a light-heat conversion layer, which ensures intimate contact to an image receiving sheet without causing image quality deterioration. From the aspect of apparatus design, on the other hand, technical key points that allow this system to be developed lie in (vi) an air ejection system adopted to a laser recording apparatus, with which a plurality of image receiving sheets having received an image can be stacked, (vii) the manner of inserting a sheet of printing paper and an image receiving sheet into a thermal transfer apparatus, in which the printing paper is superposed on the image receiving sheet placed with its image side up, which manner is effective to prevent the printing paper from curling after heat transfer, and (viii) connection to a general-purpose output drive which allows broadening of system configuration freedom. Thus, the laser thermal transfer recording system for DDCP the inventors developed is integration of various performance characteristics, system configuration,

and the technical points. This recording system is an illustrative example of means for carrying out the image formation method of the invention, and the present invention is not deemed to be limited thereto.

5 Material factors such as combinations of image forming elements (i.e., heat transfer sheets and an image receiving sheet), constituent layer configurations (e.g., a light-heat conversion layer, an image forming layer, and an image receiving layer), formulation of each element, and the like are not to
10 function dependently but to be organically linked with each other. Furthermore, these image forming elements are to play their best performance when linked with a recording apparatus and a thermal transfer apparatus. The present inventors have continued their study based on this concept. They have
15 thoroughly examined each layer of the image forming elements (inclusive of the transfer sheet and the image receiving sheet) and materials making up the layers. They have designed layers making up image forming elements in which the materials are allowed to show their characteristics to the full. They have
20 found proper ranges of various physical properties within which the image forming elements exert their full characteristics. As a result, the inventors have found out the best relations between physical properties and performance of the materials, layers, and sheets and succeeded in developing image forming
25 elements which exhibit unexpectedly high performance when

organically linked with a recording apparatus and a thermal transfer apparatus.

Significance of the present invention in the above-mentioned system developed by the inventors resides in offering multicolor image forming elements as the above-described high performance image forming elements. Therefore, the present invention is of high importance in that a multicolor image can be obtained with hues that have not been accomplished by conventional process colors.

The present invention provides a method for forming a glossy image comprising

using a (A) heat transfer sheet comprising a substrate having thereon a light-heat conversion layer and an image forming layer provided in this order wherein the light-heat conversion layer contains a polyamide-imide resin, and the image forming layer contains at least one of tabular inorganic compound particles and metal particles and a thixotropic agent (hereinafter referred to as a heat transfer sheet (A)), (B) a heat transfer sheet comprising a substrate having a light-heat conversion layer and an image forming layer provided in this order wherein the light-heat conversion layer contains a polyamide-imide resin, and the image forming layer contains a transparent colorant (hereinafter referred to as a heat transfer sheet (B)), and (C) an image receiving sheet having an image receiving layer and

imagewise transferring the image forming layer of each of the heat transfer sheets (A) and (B) to the image receiving layer by laser thermal transfer successively.

The tabular inorganic compound particles and the metal particles will sometimes be referred inclusively to "a luster pigment(s)", and the term "heat transfer sheet" is intended to include both the heat transfer sheets (A) and (B) unless specified otherwise.

It is desirable for the light-heat conversion layer of the heat transfer sheet to have an optical density (OD_{LH}) to thickness (T_{LH} ; unit: μm) ratio, OD_{LH}/T_{LH} , of 4.36 or higher. The higher the ratio, the more preferred. Taking the balance with other characteristics into consideration, however, the upper limit of the ratio would be about 10 for the time being.

The OD_{LH} of the heat transfer sheet is the absorbance of the light-heat conversion layer at the peak wavelength of laser light used for recording. The absorbance is measured with a known spectrophotometer. A UV spectrophotometer "UV-240" supplied by Shimadzu Corp. was used in the invention. The OD_{LH} is obtained by subtracting the optical density of the substrate from that of the heat transfer sheet.

The OD_{LH}/T_{LH} relates to thermal conductivity in recording and is a measure greatly influential on the sensitivity and temperature- and humidity-dependence of recording. With the OD_{LH}/T_{LH} falling within the above-recited preferred range, the

sensitivity of transfer to the image receiving sheet is increased, and recording dependence on temperature and humidity is reduced. Specifically, the OD_{LH}/T_{LH} of 4.36 or higher provides a transfer image at a high resolution preferably of 2400 dpi or more, still
5 preferably of 2600 dpi or more, and over a wide area preferably of 515 mm x 728 mm (B2 size) or wider, still preferably 594 mm x 841 mm (A1 size) or wider.

The thickness T_{LH} of the light-heat conversion layer is preferably 0.03 to 1.0 μm , still preferably 0.05 to 0.5 μm .

10 It is desirable for the image forming layer of the heat transfer sheet (B) to have an optical density (OD_I) to thickness (T_I ; unit: μm) ratio, OD_I/T_I , of 1.5 or higher, preferably 1.8 or higher, still preferably 2.50 or higher. The higher the ratio, the more desirable. Taking the balance with other
15 characteristics into consideration, however, the upper limit of the ratio would be about 6 for the time being.

The OD_I/T_I is a measure of transfer density of the image forming layer and the resolution of the transfer image. The OD_I/T_I being in the recited range, an image with a high transfer
20 density and a high resolution can be produced. A thinner image forming layer brings about increased color reproducibility.

The OD_I refers to a reflection optical density of an image re-transferred from an image receiving sheet having received the image from the transfer sheet onto Tokubishi Art (printing
25 paper available from Mitsubishi Paper Mills Ltd.), measured

on each color (e.g., yellow (Y), magenta (M), cyan (C) or black (K)) with a densitometer X-rite 938 supplied by X-Rite. That is, the OD_i of an arbitrary color-specific heat transfer sheet is the maximum density measured through a red filter for cyan, a blue filter for yellow, or a green filter for magenta. The OD_i is preferably 0.5 to 3.0, still preferably 0.8 to 2.0.

It is preferred for the image forming layer of the heat transfer sheet and the image receiving layer of the image receiving sheet to have a water contact angle of 7.0 to 120.0°, particularly 30.0 to 100.0°. The water contact angle is a measure of compatibility between the image forming layer and the image receiving layer, namely, transfer capabilities. In particular, the water contact angle of the image receiving layer is desirably 86°C or smaller. The contact angles falling in the recited range, the transfer sensitivity is increased, and the temperature and humidity dependence of recording characteristics is reduced. In the invention, the water contact angles were measured with a contact angle meter CA-A supplied by Kyowa Interface Science Co., Ltd.

Use of a surface tension reducer is effective to form a large size image. The multicolor image recording area is preferably 515 mm by 728 mm (B2 size) or wider, still preferably 594 mm by 841 mm (A1 size) or wider. The size of the image receiving sheet is 465 mm by 686 mm or wider.

The present invention will further be illustrated while

referring to the whole system previously developed by the inventors. The system according to the invention adopts a newly developed thin film thermal transfer system to accomplish high resolution and high image quality. The system is capable of
5 producing a transfer image at a high resolution of 2400 dpi or more, preferably 2600 dpi or more. The thin film thermal transfer system is such that an image forming layer as thin as 0.01 to 0.9 μm is imagewise transferred to an image receiving sheet in the state not melted or hardly melted. In other words,
10 the heat recorded area of the image forming layer is transferred while keeping its shape as thin film so that an extremely high resolution is achieved. In order to carry out thin film transfer effectively, it is preferred that the light-heat conversion layer is thermally deformed into a dome shape on being irradiated.
15 The dome-shaped light-heat conversion layer pushes the image forming layer outward, whereby the image forming layer is brought into more intimate contact with the image receiving layer and transferred thereto easily. Great deformation generates a great force pushing the image forming layer toward the image
20 receiving layer and results in easy transfer. Small deformation produces only a small pushing force and fails to accomplish sufficient transfer. Hence, the deformation should be quantified as a measure of transfer capabilities. In the invention, the degree of deformation is represented by a
25 deformation percentage obtained by dividing the

cross-sectional area (b) of the light-heat conversion layer before irradiated by the sum of the cross-sectional area (a) of the layer after irradiation and the cross-section area (b) and multiplying the quotient by 100. That is, deformation percentage (%) = $\{(a + b)/(b)\} \times 100$. The cross-sectional areas (a) and (b) are measured with a color laser 3D profile microscope VK8500 supplied by Keyence Corp. A deformation percentage preferred for thin film transfer as contemplated in the invention is 110% or higher, preferably 125% or higher, still preferably 150% or higher. While the deformation percentage could exceed 250% as long as the heat-light conversion layer has an increased elongation at break, the upper limit is usually about 250%.

The technical key points of image forming materials which can be applied to the thin film thermal transfer recording are (1) balancing between high-temperature response and storage stability (adhesion), (2) securing of intimate and full contact between the heat transfer sheet and the receiving sheet, (3) use of heat-resistant organic materials, and (4) securing of surface cleanness, as hereinafter described.

(1) Balance between high-temperature response and storage stability

The image forming layer must have a small thickness on the order of submicrons in order to attain high image quality on transfer. However, the layer should contain a pigment in

a high concentration enough to give a desired image density, which conflicts with fast thermal response. Besides, thermal response properties also conflict with storage (adhesion) stability. These conflicting problems are settled by
5 development of novel polymers and additives.

(2) Vacuum contact

In the thin film transfer technique in pursuit of high resolution, the transfer interface is desirably as smooth as possible. However, such surface smoothness interferes with
10 sufficient vacuum contact. In the present invention, departing from the common knowledge relating to vacuum contact, a matting agent having a relatively large particle size is incorporated into a layer between the substrate and the image forming layer thereby to maintain a moderate uniform gap between the transfer
15 sheet and the receiving sheet. As a result, vacuum contact capabilities are achieved without allowing the matting agent to cause dot missing and while retaining the advantages of the thin film transfer technology.

(3) Heat-resistant organic materials

20 On irradiation, the light-heat conversion layer which converts laser light energy to heat energy reaches about 700°C, and the image forming layer containing a pigment reaches about 500°C. The inventors have developed a modified polyimide capable of being applied by solvent coating techniques as a
25 material of the light-heat conversion layer. They have also

developed a pigment as a colorant of the image forming layer which is more heat-resistant than pigments for printing, safe, and fit for color matching.

(4) Surface cleanness

5 Debris or dust present between the transfer sheet and the receiving sheet leads to serious image defects in thin film transfer. To keep the image forming elements clean, material management alone is insufficient because dust outside the equipment can enter or dust can occur during sheet cutting
10 operation. It has therefore been necessary to fit the equipment with a dust removing mechanism. The inventors have found a material with moderate tackiness with which the surface of the image forming elements can be cleaned. They have thus succeeded in dust removal without accompanying productivity reduction
15 by using sheet feed rollers made of this material.

The whole system according to the invention will hereinafter be described. The present invention is contemplated to produce a heat transfer image of sharp dots, to re-transfer the transfer image to stock paper (paper actually
20 used in printing), and to achieve recording over a wide area. The system is preferably configured to carry out recording on an area of B2 size (515 mm x 728 mm) or larger, particularly 543 mm x 765 mm or larger sizes.

One of the performance features of the system developed
25 by the inventors is capability of forming sharp dots. The

resolution achievable with this system is 2400 dpi or higher,
and a transfer image having a resolution according to a desired
number of lines per inch (lpi) can be obtained by the system.
The individual dots have very sharp edges substantially free
5 from blur or deficiency. Full range of dots from highlights
to shadows can be formed clearly. Therefore, the system is
capable of outputting high quality dots at the same level of
resolution as obtained with an image setter or a CTP setter
to give an approximation to dots and gradation of final printed
10 products.

A second performance feature of the system is satisfactory
cyclic reproducibility (repeatability). Since the image
forming layer can be transferred in sharp dots, dots are
reproduced in good agreement with a laser beam. Additionally,
15 because of very small environmental dependency of recording
characteristics, the results of repetition are stable in hue
and density in a wide range of environmental conditions.

A third performance feature of the system is satisfactory
color reproducibility. Since the system employs the same
20 pigments as used in printing inks and has satisfactory cyclic
reproducibility, highly accurate color management system (CMS)
can be realized.

The heat transfer image obtained substantially matches
the color hues of final prints, i.e., the hues of SWOP
25 (specifications for web offset publications) colors or

Japan-colors and shows the same change in what it looks like with a change of lighting (between a fluorescent lamp and an incandescent lamp) as the final printed product.

A fourth performance feature of the system is satisfactory
5 text quality. Owing to the sharp dot shape, the system reproduces fine lines of letters with sharp edges.

The material technology adopted to the laser thermal transfer recording system of the invention is then described. Thermal transfer techniques for DDCP include laser sublimation,
10 laser ablation, and laser melt. The laser sublimation system and the laser ablation system result in blurred dot edges because of sublimation or scattering of a colorant. The laser melt system also fails to create clear dot outlines because the molten colorant flows. The system according to the invention adopts
15 the thin film thermal transfer system. In order to solve problems associated with the thin film thermal transfer system and to further improve the transfer image quality, the following material techniques have been added.

A first material feature of the system is a sharper dot
20 edge. In thermal transfer recording, laser light is converted to heat in the light-heat conversion layer, the heat is transmitted to the image forming layer, and the image forming layer adheres to the image receiving layer to conduct recording. In order to make sharp dots, it is required that the heat generated
25 by laser light be transmitted right to the transfer interface

without being diffused in the planar direction so that the image forming layer may be cut sharply along the borders between heated areas and non-heated areas. For this purpose, the light-heat conversion layer of the heat transfer sheet should be reduced
5 in thickness, and the dynamic characteristics of the image forming layer should be so controlled.

Accordingly, a first technique for dot sharpening is for thickness reduction of the light-heat conversion layer. As simulated, a light-heat conversion layer is assumed to
10 instantaneously reach about 700°C so that a thin light-heat conversion layer is liable to deformation or destruction. A deformed or destroyed thin light-heat conversion layer would be transferred to an image receiving sheet together with an image receiving layer or result in an uneven transfer image.
15 Beside this problem, a light-heat conversion layer must have a light-heat converting substance in a high concentration so as to reach a prescribed temperature, which can cause additional problems such as colorant's precipitation or migration to an adjacent layer. To address these problems, the heat transfer
20 sheet of the invention employs an infrared absorbing colorant as a light-heat converting substance which is effective at a reduced amount compared with carbon that has been often used as a light-heat converting substance. With respect to a binder, a polyimide compound is chosen in the invention, which retains
25 sufficient mechanical strength even at high temperatures and

has satisfactory ability to hold an infrared absorbing colorant.

In this way, it is preferred to reduce the light-heat conversion layer thickness to about 0.5 μm or smaller by selecting an infrared absorbing colorant exhibiting excellent light-heat conversion characteristics and a heat-resistant binder such as a polyimide resin.

A second technique for dot sharpening is for improving the characteristics of the image forming layer. If the light-heat conversion layer is deformed, or if the image forming layer itself undergoes deformation due to high heat, the image forming layer transferred to the image receiving layer suffers from thickness unevenness in response to the slow scanning pattern of a laser beam. It follows that the transfer image becomes non-uniform with reduced apparent transfer densities. This tendency becomes conspicuous with a decrease in image forming layer thickness. On the other hand, a thick image forming layer has poor dot sharpness and reduced sensitivity.

In order to solve these problems, it is preferred to reduce transfer unevenness by adding a low-melting substance, such as a wax, to the image forming layer. Furthermore, inorganic fine particles can be added in place of part of binders to increase the layer thickness to a proper degree so that the image forming layer may be sharply cut along the heated area/non-heated area interface. As a result, uniform recording can be accomplished without impairing dot sharpness and

sensitivity.

In general, low-melting substances such as waxes tend to bleed on the surface of the image forming layer or to crystallize, which can result in impairment of image quality or deterioration of stability of the heat transfer sheet with time. To address this drawback, it is preferred to select a low-melting substance with a small difference in S_p (solubility parameter) value from the polymer of the image forming layer. Such a substance exhibits improved compatibility with the polymer and is prevented from releasing from the image forming layer. It is also preferred for averting crystallization that a plurality of low-melting substances having different structures are mixed into an eutectic mixture. By these manipulations an image of sharp dots free from unevenness can be obtained.

A second material feature of the system owes to the finding that thermal transfer recording sensitivity is dependent on temperature and humidity. In general, the heat transfer sheet changes its mechanical and thermal characteristics on moisture absorption, which means environmental humidity dependence of recording. In order to reduce the temperature and humidity dependence, it is preferred that the colorant/binder system of the light-heat conversion layer and the binder system of the image forming layer be of an organic solvent system. It is also preferred to choose polyvinyl butyral as a binder of

the image receiving layer and to introduce a polymer hydrophobilization technique for reducing the water absorption of polyvinyl butyral. Available polymer hydrophobilization techniques include causing a hydroxyl group of a polymer to
5 react with a hydrophobic group as taught in JP-A-8-238858 and crosslinking two or more hydroxyl groups of a polymer with a hardening agent.

A third material feature of the system lies in improvement on hue approximation to the final output. The system of the
10 invention has introduced the knowledge about color matching management and stable dispersing technique amassed through the development of a thermal head type color proofer (e.g., First Proof supplied by Fuji Photo Film Co., Ltd.) and also settled the following problem that has arisen in the laser thermal
15 transfer system.

A first technique for achieving improved hue approximation to the final output consists in use of a highly heat-resistant pigment. An image forming layer generally reaches about 500°C in thermal transfer recording by laser light.
20 Some of traditionally employed pigments decompose at such high temperatures. This problem is averted by using highly heat-resistant pigments in the image forming layer.

A second technique realizing improved hue approximation to the final output resides in prevention of the infrared
25 absorbing dye from diffusing. If the infrared absorbing dye

used in the light-heat conversion layer migrates to the image forming layer due to the high recording heat, it follows that the hue of a resultant transfer image differs from what is expected. To prevent this, the light-heat conversion layer
5 is preferably made of the infrared absorbing dye combined with the above-described binder capable of securely holding the infrared absorbing dye.

A fourth material feature of the system is achievement of high sensitivity. In high-speed recording with laser light,
10 shortage of light energy often occurs to cause gaps, particularly gaps corresponding to the scanning pitch in the slow scanning direction. To address the problem, the high concentration of a colorant (pigment) in the light-heat conversion layer and the small thicknesses of the light-heat conversion layer and
15 the image forming layer serve to increase the efficiency of heat generation and heat conduction as previously stated. Additionally, it is preferred to incorporate a low-melting substance into the image forming layer. By so doing, the image forming layer is made capable of flowing slightly to such an
20 extent as to fill the gaps, and the adhesion of the image forming layer to the image receiving layer is improved. It is also preferred to use polyvinyl butyral, which is a preferred binder for use in the image forming layer, as a binder of the image receiving layer so as to increase the adhesion between the image
25 receiving layer and the image forming layer and to ensure the

film strength of the transfer image.

A fifth material feature of the system is improvement on vacuum holding. The image receiving sheet and the heat transfer sheet are preferably held on a recording drum by vacuum holding. The contact of the two sheets by vacuum holding is of great significance because image transfer relies on control of adhesion between the image receiving layer of the image receiving sheet and the image forming layer of the transfer sheet, and the transfer behavior is very sensitive to the clearance therebetween. An increased gap between the two sheets due to dust or debris results in image defects or transfer unevenness. To prevent such image defects and transfer unevenness, it is preferred to give uniform surface roughness to the heat transfer sheet thereby allowing entrapped air to escape to make a uniform clearance between the two sheets.

Surface roughness is given to the heat transfer sheet side so that the effect of vacuum contact may be fully enjoyed when two or more color images are overprinted. The heat transfer sheet can be textured by post-treatments such as embossing or addition of a matting agent. Addition of a matting agent is preferred for the sake of process simplification and in view of material stability with time. A matting agent to be added should have a particle size larger than the thickness of a layer to which it is added. Addition of a matting agent directly to the image forming layer would result in missing of dots from

the part where the matting agent particles stick out. This is the reason why a matting agent of optimum particle size is preferably added to the light-heat conversion layer. As a result, the image forming layer provided thereon has an almost
5 uniform thickness and is capable of transferring a defect-free image to the image receiving sheet.

The systematization of the technique according to the present invention will then be described.

A first feature of the systematization is configuration
10 of the recording apparatus. In order to duly reproduce sharp dots, not only the image forming elements but also the recording apparatus should be designed precisely. The recording apparatus which can be used has the same basic configuration as conventional thermal transfer recorders. This
15 configuration is a so-called heat mode outer drum recording system in which a heat transfer sheet and an image receiving sheet held on a drum are irradiated with a recording head having a plurality of high power lasers. The following embodiments are preferred among others.

20 Firstly, the recording apparatus is designed to avoid contamination with dust. The image receiving sheet and the heat transfer sheet are supplied by a full-automatic roll supply system so as to avoid contamination with dust or debris that might enter when the recording apparatus is manually loaded
25 with a stack of cut sheets. A loading unit containing rolls

of the heat transfer sheets, one roll for one color, rotates to bring each roll to the position where the roll is cut at a prescribed length with a cutter, and the cut sheet is held onto a recording drum.

5 Secondly, the recording apparatus is designed to bring the image receiving sheet and the heat transfer sheet into intimate contact on the recording drum. The image receiving sheet and the heat transfer sheet are held to the drum by suction (vacuum holding). Mechanical holding fails to bring the two
10 sheets into such intimate contact as obtained by vacuum holding. A large number of suction holes are formed on the recording drum, and the inside of the drum is evacuated with a blower or a vacuum pump thereby to hold the sheets onto the drum. The image receiving sheet is the first to be held by suction, and
15 the heat transfer sheet is superposed thereon. Therefore, the heat transfer sheet is made larger than the image receiving sheet so as to have extensions over every side of the image receiving sheet. Air between the heat transfer sheet and the image receiving sheet, which greatly influences the image
20 transfer, is sucked from the extension area of the heat transfer sheet extending from the underlying image receiving sheet.

 Thirdly, the recording apparatus is designed to allow a plurality of output sheets to be stacked stably on an output tray. In the present invention, the recording apparatus is
25 contemplated to provide output sheets of B2 or larger sizes

being stacked on the output tray. When a sheet is outputted and superposed on another sheet that has already been discharged, the two sheets can stick to each other because of the heat stickiness of the image receiving layer. If this happens, the next sheet is not discharged in good order to cause jamming. To prevent this from happening, it is the best to prevent the output sheets from coming into contact with each other. Known means for preventing the contact include (a) a level difference made on the output tray, by which the sheet is placed non-flat, and a gap is created between adjacent sheets, (b) a slot for output exit positioned higher than the output tray so that an output sheet discharged through the slot drops on the output tray, and (c) air ejected between adjacent sheets to float the upper sheet. Since the sheet size is as large as B2, application of the means (a) or (b) will make the apparatus considerably larger. Therefore, the means (c), i.e., an air ejection method is employed in this system.

Fig. 2 shows a recording apparatus 1 as an example of the recording apparatus which can be used in the invention.

Referring to Fig. 2, steps for full color image formation by use of the image forming elements according to the invention and the above-described recording apparatus are illustrated below in sequence.

1) A recording head 2 which slides on rails 3 in the slow scan (sub-scan) direction, a recording drum 4 which rotates

in the fast scan (main scan) direction, and a heat transfer sheet loading unit 5 return to their starting positions.

2) An image receiving sheet is unrolled from an image receiving sheet roll 6 with feed rollers 7, and the leading end of the image receiving sheet is fixed by suction onto the recording drum 4 through suction holes of the recording drum.

3) A squeeze roller 8 comes down and presses the leading end of the image receiving sheet onto the recording drum 4.

In this state, the drum 4 rotates to further unroll the image receiving sheet. When a given length is unrolled, the drum stop rotating, and a cutter 9 cuts the unrolled sheet.

4) The recording drum 4 further turns to makes one revolution to complete image receiving sheet loading.

5) A heat transfer sheet (A) of the first color, i.e., a luster pigment, is unrolled from a heat transfer sheet roll 10A, held onto the recording drum 4, and cut into a sheet of prescribed length according to the same sequence as for the image receiving sheet.

6) The recording drum 4 starts to rotate at high speed, and the recording head 2 starts to move on the rails 3. When the recording head 2 arrives at a record starting position, it emits writing laser beams to irradiate the transfer material (heat transfer sheet and the image receiving sheet) held on the recording drum 4 according to recording signals. The irradiation

is stopped at a recording terminal position, and the operations

of the rails 3 and the drum 4 stop. The recording head 2 on the rails 3 returns to its starting position.

7) Only the heat transfer sheet (A) is peeled off with the image receiving sheet left on the recording drum. The leading
5 end of the heat transfer sheet (A) is caught in claws, pulled apart from the image receiving sheet, and discarded through a discard slot 32 into a waste box 35.

8) The steps (5) to (7) are repeated for each of the heat transfer sheets (B). Recording is performed in the order of,
10 for example, K, C, M, and Y. In some cases, red follows, or blue, orange, etc. follow. That is, a heat transfer sheet of the second color K, a heat transfer sheet of the third color C, a heat transfer sheet of the fourth color M, and a heat transfer sheet of the fifth color Y are successively fed from rolls 10K,
15 10C, 10M, and 10Y, respectively. The order of color superimposition in the recording apparatus is the reverse of the general printing order because the resulting color image is reversed on re-transfer to paper to give a color proof. The order of color superimposition is not particularly limited.
20 For example, the heat transfer sheet (B) may be used in the step (5), and the heat transfer sheet (A) may be used in the step (8).

9) After completion of the above steps, the recorded image receiving sheet is discharged on an output tray 31. The image
25 receiving sheet is separated from the recording drum in the

same manner as for the heat transfer sheets (as described in step (7)) but is not discarded. When it comes near the discard slot 32, it changes its direction by a switchback mechanism and is forwarded to the output tray. When the image receiving
5 sheet exits through the discharge slot 33, air 34 is blown from under the slot 33 to allow a plurality of sheets to be stacked without sticking to each other.

It is preferred to use an adhesive roller as one of paired feed rollers 7 disposed on any site between the recording drum
10 4 and each of the image receiving sheet roll and the heat transfer sheet roll to clean the surface of the heat transfer sheet and the image receiving sheet.

The adhesive roller has a pressure-sensitive adhesive on its surface. The pressure-sensitive adhesive includes an
15 ethylene-vinyl acetate copolymer, an ethylene-ethyl acrylate copolymer, a polyolefin resin, a polybutadiene resin, a styrene-butadiene copolymer (SBR), a styrene-ethylene-butene-styrene copolymer (SEBS), an acrylonitrile-butadiene copolymer (NBR), a polyisoprene resin
20 (IR), a styrene-isoprene copolymer (SIS), an acrylic ester copolymer, a polyester resin, a polyurethane resin, an acrylic resin, butyl rubber, and polynorbornene.

The surface of the heat transfer sheet and the image receiving sheet can be cleaned on contact with the adhesive
25 roller. The contact pressure is not particular limited.

It is preferred that the pressure-sensitive adhesive used in the adhesive roller has a Vickers hardness H_v of 50 kg/mm² (≈ 490 MPa) or less for thoroughly removing dust and thereby preventing image defects caused by dust. "Vickers hardness" is a hardness measured by applying a static load to a quadrilateral diamond indenter having an angle of 136° between the opposite faces. Vickers hardness H_v is obtained from equation:

$$H_v = 1.854 P/d^2 \text{ (kg/mm}^2\text{)} \approx 18.1692 P/d^2 \text{ (MPa)}$$

where P is a load (kg) applied, and d is the length (mm) of a diagonal of a square indentation.

It is also preferred for the pressure-sensitive adhesive to have an elastic modulus of 200 kg/cm² (≈ 19.6 MPa) or less at 20°C for the same purpose as described above.

A second feature of the systematization is configuration of a heat transfer apparatus. A heat transfer apparatus is used to re-transfer the transfer image on the image receiving sheet to a sheet of same paper as used in final printing (hereinafter simply referred to as a paper sheet). This method is entirely identical to that of First Proof (a registered trade mark of a thermal transfer apparatus available from Fuji Photo Film Co., Ltd.). A paper sheet is superposed on the image receiving sheet, and heat and pressure are applied thereto to

adhere the two sheets together. Then, the image receiving sheet is stripped off the paper sheet, whereby only the substrate and a cushioning layer (if provided as hereinafter described) of the image receiving sheet are removed to leave the image and the image receiving layer on the paper sheet. This practically means that the image is transferred from the image receiving sheet to the printing paper sheet.

In First ProofTM, image re-transfer is performed by superposing a paper sheet and the image-receiving sheet on an aluminum guide plate and passing them through a pair of heat rollers. The aluminum guide plate serves to prevent the paper from deformation. If this design is applied as such to the system for B2 size output, the aluminum guide plate should be larger than a B2 size, which results in the problem that a large installation space is required. Accordingly, the system of the present invention does not use such an aluminum guide plate. Instead, the carrier path turns 180° so that the sheets are discharged toward the loading side. As a result, the installation space can be largely saved (see FIG. 3). However, there arises another problem that the paper sheet is curled in the absence of an aluminum guide plate. The facing couple of the paper sheet and the image-receiving sheet curls with the image-receiving sheet inward and rolls on the output tray. It is very difficult to separate the image receiving sheet from the curled paper.

In the present invention, this curling phenomenon is averted by taking advantage of bimetallic effect due to the difference in shrinkage between printing paper and the image receiving sheet and the ironing effect of the heat roller. Where
5 an image receiving sheet is superposed on a paper sheet as in a conventional way, the two sheets curl with the image receiving sheet inward by bimetallic effect upon heating because the image receiving sheet shows larger thermal shrinkage in the direction of insertion than printing paper. The direction of curling
10 by the bimetallic effect is the same as the direction of curling by the ironing effect of the heat roller around which the two sheets are wound. As a result, the curling becomes serious by synergism. In contrast, when the paper sheet is superposed on an image receiving sheet, downward curling by the bimetallic
15 effect occurs whereas upward curling is caused by ironing effect so that the curls of opposite directions are offset by each other.

Re-transfer to printing paper is carried out according to the following sequence. A thermal transfer apparatus 41
20 which can be used for re-transfer is shown in Fig. 3. Unlike the laser recording apparatus, the thermal transfer apparatus 41 is manually operated.

1) To begin with, dials (not shown) are turned to set the temperature of heat rollers 43 (variable between 100° and 110°C)
25 and the transfer speed according to the kind of printing paper

42.

2) An image receiving sheet 20 is put on an insertion table 44 with the image side up, and the dust on the image is removed by an antistatic brush (not shown). A paper sheet 42 from which dust has been removed is superposed thereon. Because the upper paper sheet 42 is larger than the lower image receiving sheet 20, it is difficult to position the paper sheet 42 on the image receiving sheet 20 hidden from the eye. For improving the ease of the positioning work, marks 45 indicating the positions of placement for an image receiving sheet 20 and a paper sheet 45 are made on the insertion table 44. The reason the paper sheet is larger than image-receiving sheet 20 is to prevent image receiving sheet 20 from coming out under the paper sheet 42 and staining heat roller 43.

3) The image receiving sheet and the paper sheet are inserted into an insert port, and a pair of insert rollers 46 rotates to feed them to heat rollers 43.

4) When the leading end of the paper sheet 42 reaches the heat rollers 43, the heat rollers nip the two sheets to start heat transfer. The heat rollers are heat resisting silicone rubber rollers. Pressure and heat are applied simultaneously to the image receiving sheet and the paper sheet to adhere them. A heat-resistant guide sheet 47 is provided by the upper heat roller. The image receiving sheet and the paper sheet are carried upward through between the upper heat roller and the

guide sheet 47 while being heated, separated from the upper heat roller by separation claw 48, and guided to an output slot 50 along a pair of guide plates 49.

5) The image receiving sheet and the paper sheet coming out of the output slot 50 is discharged on the insertion table while being adhered. Thereafter, the image receiving sheet 20 is separated from the paper sheet 42 manually.

The second feature of the systematization technique resides in the system configuration.

10 The above-illustrated apparatus are connected to a plate-making system to perform the function as a color proofer. A color proofing system is required to output a color proof as an approximation to final prints outputted based on certain page data. Therefore, software for approximating dots and
15 colors to the final prints is necessary. A specific example of connection is shown below. Fig. 4 is referred to.

When a proof is to be prepared for the final printing product outputted from a plate-making system Celebra™ (from Fuji Photo Film Co., Ltd.), a CTP system is connected to Celebra.
20 A printing plate outputted from this connection is mounted on a press to carry out actual printing. To Celebra is connected the above-illustrated thermal transfer recording apparatus as a color proofer, e.g., Luxel FINALPROOF 5600 from Fuji Photo Film Co., Ltd. (hereinafter simply referred to as FINALPROOF),
25 and proof drive software PD SYSTEM™ available from Fuji Photo

Film is installed between Celebra and FINALPROOF for approximating dots and colors to the final output.

Contone data (continuous tone data) converted to raster data by Celebra are converted to binary data for dots, outputted
5 to the CTP system, and finally printed. On the other hand, the same contone data are also sent to PD SYSTEM. PD SYSTEM converts the received data according to a multi-dimensional table for each color so that the colors may agree with the final output. Finally the data are converted to binary data for dots
10 so as to agree with the dots of the final output, which are sent to FINALPROOF.

The multi-dimensional table for each color is experimentally prepared in advance and stored in the system. The experiment for the preparation of the multi-dimensional
15 table is as follows. Data of an important color are outputted via the CTP system to prepare a printed image. The same data are also outputted from FINALPROOF via PD SYSTEM to prepare a proof image. The measured color values of these images are compared, and a table is prepared so as to minimize the
20 difference.

Thus, the system configuration was set up so that the performance of the high-resolution image forming elements of the invention may be exhibited to the full.

The heat transfer sheet used in the above-described system
25 is then described.

It is preferred that the absolute value of the difference between the surface roughness R_z (defined later) of the exterior side of the image forming layer of the heat transfer sheet and that of the opposite side (interior side) of the image-forming layer be 3.0 or smaller and that the absolute value of the difference between the surface roughness R_z of the exterior side of the image-receiving layer of the image receiving sheet and that of the opposite side (interior side) of the image receiving layer be 3.0 or smaller. Such a layer design combined with the above-described cleaning means prevents image defects and jamming in the sheet path and reduces variations in dot gain.

The surface roughness R_z is a 10 point height parameter corresponding to the R_z (maximum height) specified in JIS B 0601. The surface roughness R_z is obtained by computing the average height difference between the five highest peaks and the five lowest valleys with respect to the mean plane within an evaluation area. A stylus type 3D roughness meter (Surfcom 570A-3DF, available from Tokyo Seimitsu Co., Ltd.) is used for measurement. The measurement is performed in the longitudinal direction, the cut-off length is 0.08 mm, the evaluation area is 0.6 mm by 0.4 mm, the sampling pitch is 0.005 mm, and the speed of measurement is 0.12 mm/sec.

For enhancing the above-described effects, it is still preferred that the absolute difference between the R_z of the

exterior surface of the image forming layer and that of the opposite side of the image forming layer be 1.0 or smaller and that the absolute difference between the Rz of the exterior side of the image receiving layer and that of the opposite side of the image receiving layer be 1.0 or smaller.

In another layer design, it is preferred that the surface roughness Rz of both the exterior side and the interior side of the image forming layer of the heat transfer sheet and/or both the exterior side and the interior side of the image receiving layer of the image receiving sheet be in a range of from 2 to 30 μm . Such a layer design combined with the above-described cleaning means prevents image defects and jamming in the sheet path and reduces variations in dot gain.

The scheme of multicolor image formation by thin film thermal transfer using a laser is described by referring to Fig. 1.

An image forming laminate 30 composed of a heat transfer sheet (A) indicated by reference numeral 10a and an image receiving sheet 20 is prepared (see Fig. 1A). The heat transfer sheet (A) 10a comprises a substrate 12a, a light-heat conversion layer 14a provided on the substrate 12a, and an image forming layer 16a containing a luster pigment (tabular inorganic compound particles and/or metal particles) provided on the light-heat conversion layer 14. The image receiving sheet 20 has a substrate 22 and an image receiving layer 24. The two

of two-dimensional array means a plurality of laser beams arranged in a two-dimensional array such that the spots of these laser beams form a plurality of lines in the fast scan direction and a plurality of rows in the slow scan direction. Use of
5 multibeam in a two-dimensional array reduces the time required for laser recording.

Laser beam of any kind can be used in recording with no limitation, including direct laser beams such as gas laser beams, e.g., an argon ion laser beam, a helium neon laser beam, and
10 a helium cadmium laser beam, solid state laser beams, e.g., a YAG laser beam, a semiconductor laser beam, a dye laser beam, and an excimer laser beam. Light rays obtained by converting these laser beams to half the wavelength through a second harmonic generation device can also be used. In multicolor
15 image formation, semiconductor laser beams are preferably used taking the output power and ease of modulation into consideration. In multicolor image formation, a laser beam is preferably emitted to give a spot diameter of 5 to 50 μm , particularly 6 to 30 μm , on the light-heat conversion layer. The scanning speed is
20 preferably 1 m/sec or higher, still preferably 3 m/sec or higher. The output power of a laser beam is preferably 0.5 W or higher.

In multicolor image formation, the thickness of the black image forming layer in the black heat transfer sheet is preferably larger than that of the other color image forming
25 layers in the yellow, magenta and cyan heat transfer sheets

and preferably ranges from 0.5 to 0.7 μm . This layer design is effective to prevent density reduction due to non-uniform transfer of the black image forming layer. With the thickness being 0.5 μm or greater, the black image forming layer can be
5 uniformly transferred when recorded with high energy thereby attaining a satisfactory image density necessary as a color proof for printing. Since the tendency to transfer unevenness becomes conspicuous under high humidity conditions, the thickness of 0.5 μm or greater is particularly effective to
10 reduce environment-induced variations in density. On the other hand, the black image forming layer thickness of 0.7 μm or smaller is effective in maintaining the transfer sensitivity in laser recording and improving reproducibility of small dots and fine lines. These effects are more conspicuous under lower
15 humidity conditions. Resolution can also be improved with the above layer thickness. The layer thickness of the black image forming layer of the black heat transfer sheet is still preferably 0.55 to 0.65 μm , particularly preferably 0.60 μm .

In addition to the black image forming layer thickness
20 ranging 0.5 to 0.7 μm , it is preferred that the thickness of the other color image forming layers of the yellow, magenta and cyan heat transfer sheets be from 0.2 to less than 0.5 μm . The 0.2 μm or greater thickness of the yellow, magenta or cyan image forming layer is effective to prevent transfer unevenness
25 thereby to maintain the image density in laser recording. The

0.5 μm or smaller thickness of these color image forming layers results in improved transfer sensitivity and resolution. A still preferred thickness of the yellow, magenta and cyan image forming layers is from 0.3 to 0.45 μm .

5 The thickness of the image forming layer containing the luster pigment is preferably 0.05 to 5 μm . A thickness of 0.05 μm or greater enables transfer, and a thickness of 5 μm or smaller is advantageous for resolution. A still preferred thickness is 0.1 to 3 μm .

10 It is preferred for the image forming layer of the black heat transfer sheet to contain carbon black. The carbon black to be incorporated preferably comprises at least two kinds different in tinting strength from the viewpoint of ease of controlling reflection density while maintaining a P/B
15 (pigment/binder) ratio within a specific range.

 The tinting strength of carbon black can be represented in various terms. PVC blackness disclosed in JP-A-10-140033 is among them. PVC blackness of carbon black is determined as follows. Carbon black to be evaluated is dispersed in a
20 polyvinyl chloride resin by a two-roll mill and molded into a sheet. The blacknesses of Carbon Black #40 and #45, both available from Mitsubishi Chemicals Co., Ltd. being taken as 1 point and 10 points, respectively, the PVC blackness of the sample sheet is rated by visual observation on a 10 point scale.
25 Two or more carbon blacks having different PVC blacknesses can

be used in appropriate combination according to the purpose.

The following components were kneaded in a 250 cc Banbury mixer at 115°C for 4 minutes to prepare a master batch having a carbon black content of 40% by weight.

5 Master batch formulation:

Low-density linear polyethylene (LDPE)	101.89 g
Calcium stearate	1.39 g
Irganox 1010	0.87 g
Carbon black	69.43 g

10 The master batch was diluted according to the following formulation in a two-roll mill at 120°C to prepare a compound having a carbon black content of 1% by weight.

Compound formulation:

LDPE	58.3 g
15 Calcium stearate	0.2 g
Carbon black master batch	1.5 g

The resulting compound is extruded through a slit width of 0.3 mm, and the extruded sheet is cut into chips. The chips are molded into a film having a thickness of 65±3 µm on a hot
20 plate set at 240°C.

The method of forming a multicolor image according to the present invention includes the above-described method comprising successively transferring a plurality of images on the same image receiving sheet by using the heat transfer sheets
25 A and B to form a multicolor image on the image receiving sheet

and a method comprising separately transferring images of the heat transfer sheets A and B to as many image receiving sheets as the heat transfer sheets and re-transferring the transfer images onto printing paper, etc. to form a multicolor image on the paper.

More specifically, the latter method is carried out, for example, as follows. A laminate of an image receiving sheet and a heat transfer sheet is prepared for each of the luster pigment and colorants different in hue (e.g., cyan, magenta, yellow, black, and red). Each laminate is irradiated with laser light through a color separation filter in accordance with the respective digital signals, and the heat transfer sheet is stripped off the image receiving sheet to obtain a color separated image for each color on the image receiving sheet. Thereafter, the color separated images are successively re-transferred to an actual support, such as printing paper or an equivalent, to form a multicolor image.

While the aforementioned laser thermal transfer recording technology is preferably applied to thin film thermal transfer recording, it is also applicable to other thermal transfer systems, such as melt transfer recording, ablation transfer recording, and sublimation transfer recording. Therefore, the system of the invention includes in its scope the image forming elements useful in these other thermal transfer recording systems.

The heat transfer sheets (A) and (B) and the image receiving sheet according to the present invention will be described in detail.

The heat transfer sheet comprises a substrate, a
5 light-heat conversion layer, and an image forming layer, wherein the light-heat conversion layer contains a polyamide-imide resin as a binder. The heat transfer sheet (A) contains a luster pigment and a thixotropic agent in its image forming layer. The heat transfer sheet (B) contains a transparent colorant
10 in its image forming layer. If desired, the heat transfer sheet may have an additional layer. One or more than one heat transfer sheets A and/or one or more than one heat transfer sheets (B) may be used in forming a multicolor image.

The substrate of the heat transfer sheet can be of any
15 material of choice. It is desirable for the substrate to have stiffness, dimensional stability, and heat resistance withstanding the heat of laser recording. Preferred substrate materials include synthetic resins, such as polyethylene terephthalate, polyethylene-2,6-naphthalate, polycarbonate,
20 polymethyl methacrylate, polyethylene, polypropylene, polyvinyl chloride, polyvinylidene chloride, polystyrene, styrene-acrylonitrile copolymers, polyamide (aromatic or aliphatic), polyimide, polyamide-imide, and polysulfone. A biaxially stretched polyethylene terephthalate film is
25 preferred of them from the standpoint of mechanical strength

and dimensional stability against heat. In the preparation of color proofs by laser recording, the substrate of the heat transfer sheet is preferably made of transparent synthetic resins which transmit laser beams. The thickness of the substrate is preferably 25 to 130 μm , still preferably 50 to 120 μm . The substrate preferably has a central-line average surface roughness R_a of less than 0.1 μm on its image forming layer side. In the present invention R_a values are measured with a profilometer Surfcom available from Tokyo Seiki Co., Ltd. according to JIS B0601. The substrate preferably has a Young's modulus of 200 to 1200 kg/mm^2 (≈ 2 to 12 GPa) in the machine direction (MD) and of 250 to 1600 kg/mm^2 (≈ 2.5 to 16 GPa) in the transverse direction (TD). The F-5 value of the substrate in the MD is preferably 5 to 50 kg/mm^2 (≈ 49 to 490 MPa), and that in the TD is preferably 3 to 30 kg/mm^2 (≈ 29.4 to 294 MPa). The F-5 value in the MD is generally higher than that in the TD, but this is not the case when the substrate is required to be stronger in the TD than in the MD. The thermal shrinkage of the substrate when treated at 100°C for 30 minutes is preferably 3% or less, still preferably 1.5% or less, in both TD and MD. The thermal shrinkage at 80°C for 30 minutes is preferably 1% or less, still preferably 0.5% or less, in both MD and TD. The substrate preferably has a breaking strength of 5 to 100 kg/mm^2 (≈ 49 to 980 MPa) in both directions and an elastic modulus of 100 to 2,000 kg/mm^2 (≈ 0.98 to 19.6 GPa) at

20°C.

In order to improve adhesion between the substrate and the light-heat conversion layer, the substrate may be subjected to a surface activation treatment and/or be provided with one or more undercoating layers. The surface activation treatment includes glow discharge treatment and corona discharge treatment. The material of the undercoating layer is preferably selected from those having high adhesion to both the substrate and the light-heat conversion layer, low heat conductivity, and high heat resistance. Such materials include polystyrene, a styrene-butadiene copolymer, and gelatin. The total thickness of the undercoating layers is generally 0.01 to 2 μm . If desired, the opposite side of the substrate may also be surface-treated or provided with a functional layer, such as an antireflection layer or an antistatic layer. It is particularly advisable to provide a backcoating layer containing an antistatic agent on the back of the substrate.

The backcoating layer preferably comprises a first backcoating layer contiguous to the substrate and a second backcoating layer provided on the first backcoating layer. It is preferred that the weight ratio of the antistatic agent B contained in the second backcoating layer to the antistatic agent A contained in the first backing layer, B/A , be less than 0.3. A B/A ratio of 0.3 or more tends to result in reduction of sliding properties and cause powder fall-off from the

backcoating layer.

The thickness C of the first backcoating layer is preferably 0.01 to 1 μm , still preferably 0.01 to 0.2 μm . The thickness D of the second backcoating layer is preferably 0.01 to 1 μm , still preferably 0.01 to 0.2 μm . The thickness ratio C/D is preferably 1/2 to 5/1.

The antistatic agents which can be used in the first and second backcoating layers include nonionic surface active agents, e.g., polyoxyethylene alkylamines and glycerol fatty acid esters; cationic surface active agents, e.g., quaternary ammonium salts; anionic surface active agents, e.g., alkylphosphates; amphoteric surface active agents; and electrically conductive resins.

Electrically conductive fine particles can also be used as an antistatic agent. Examples of such electrically conductive fine particles include oxides, e.g., ZnO, TiO_2 , SnO_3 , Al_2O_3 , In_2O_3 , MgO, BaO, CoO, CuO, Cu_2O , CaO, SrO, BaO_2 , PbO, PbO_2 , MnO_2 , MoO_3 , SiO_2 , ZrO_2 , Ag_2O , Y_2O_3 , Bi_2O_3 , Ti_2O_3 , Sb_2O_3 , Sb_2O_5 , $\text{K}_2\text{Ti}_6\text{O}_{13}$, $\text{NaCaP}_2\text{O}_{18}$, and MgB_2O_5 ; sulfides, e.g., CuS and ZnS; carbides, e.g., SiC, TiC, ZrC, VC, NbC, MoC, and WC; nitrides, e.g., Si_3N_4 , TiN, ZrN, VN, NbN, and Cr_2N ; borides, e.g., TiB_2 , ZrB_2 , NbB_2 , TaB_2 , CrB, MoB, WB, and LaB_5 ; silicides, e.g., TiSi_2 , ZrSi_2 , NbSi_2 , TaSi_2 , CrSi_2 , MoSi_2 , and WSi_2 ; metal salts, e.g., BaCO_3 , CaCO_3 , SrCO_3 , BaSO_4 , and CaSO_4 ; and composites, e.g., SiN_4/SiC and $9\text{Al}_2\text{O}_3/2\text{B}_2\text{O}_3$. These electrically conductive fine particles

may be used either alone or in combination of two or more thereof. Preferred of them are SnO_2 , ZnO , Al_2O_3 , TiO_2 , In_2O_3 , MgO , BaO , and MoO_3 . Still preferred are SnO_2 , ZnO , In_2O_3 , and TiO_2 , with SnO_2 being particularly preferred.

5 In laser thermal transfer recording, the antistatic agents used in the backcoating layer are preferably substantially transparent so as to transmit laser beams.

 In using an electrically conductive inorganic compound fine particles explained above as the antistatic agent, the
10 particle size is preferably smaller to minimize light scattering, but the particle size should be determined based on the ratio of the refractive index of the particles to that of the binder as a parameter, which can be obtained according to Mie theory. The average particle size of the electrically conductive
15 inorganic compound fine particles is generally 0.001 to 0.5 μm , preferably 0.003 to 0.2 μm . The term "average particle size" as used herein is intended to cover not only primary particles but agglomerates.

 The first and second backcoating layers may further
20 contain a binder and various other additives, such as surface active agents, slip agents, and matting agents. The amount of the antistatic agent in the first backcoating layer is preferably 10 to 1,000 parts by weight, still preferably 200 to 800 parts by weight, per 100 parts by weight of the binder.
25 The amount of the antistatic agent in the second backcoating

layer is preferably 0 to 300 parts by weight, still preferably 0 to 100 parts by weight, per 100 parts by weight of the binder.

The binders which can be used in the first and second backcoating layers include homopolymers and copolymers of acrylic monomers, e.g., acrylic acid, methacrylic acid, acrylic esters and methacrylic esters; cellulosic polymers, e.g., nitrocellulose, methyl cellulose, ethyl cellulose, and cellulose acetate; polymers of vinyl compounds, e.g., polyethylene, polypropylene, polystyrene, vinyl chloride copolymers, vinyl chloride-vinyl acetate copolymers, polyvinyl pyrrolidone, polyvinyl butyral, and polyvinyl alcohol; condensed polymers, e.g., polyester, polyurethane, and polyamide; elastic thermoplastic polymers, e.g., butadiene-styrene copolymers; polymers obtained by polymerization or crosslinking of photopolymerizable or heat polymerizable compounds, e.g., epoxy compounds; and melamine compounds.

The light-heat conversion layer comprises a light-heat converting substance and a binder. If necessary, it can contain a matting agent. It may further contain other additives, if desired.

The light-heat conversion layer of the heat transfer sheet according to the invention contains a polyamide-imide resin as a binder. The polyamide-imide resin to be used is not particularly limited as long as it dissolves in a solvent and

functions as a binder. It is preferred for the polyamide-imide resin to have such strength as to form a layer on the substrate and a high heat conductivity. It is also preferred for the polyamide-imide resin to have such heat resistance so as not to decompose by the heat generated by the light-heat conversion layer. Heat-resistant resins maintain the surface smoothness of the light-heat conversion layer after irradiation with high energy laser beams.

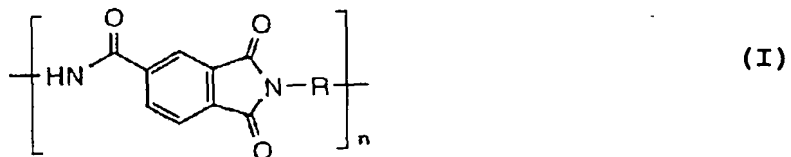
The polyamide-imide resin as a binder preferably has a heat decomposition temperature of 400°C or higher, particularly 500°C or higher, as measured by TGA (thermogravimetric analysis). The heat decomposition temperature as used herein means the temperature at which a sample reduces its weight by 5% when heated in an air stream at a temperature rise rate of 10°C/min.

The polyamide-imide resin preferably has a glass transition temperature (T_g) of 200 to 400°C, still preferably 250 to 350°C. Resins having a T_g lower than 200°C tend to cause fogging. Resins having a T_g higher than 400°C have reduced solubility in a solvent, which can result in reduction of productivity.

It is preferred for the binder of the light-heat conversion layer to have higher heat resistance (e.g., heat deformation temperature and heat decomposition temperature) than the materials used in other layers of the light-heat conversion layer.

The polyamide-imide resin which is preferably used in

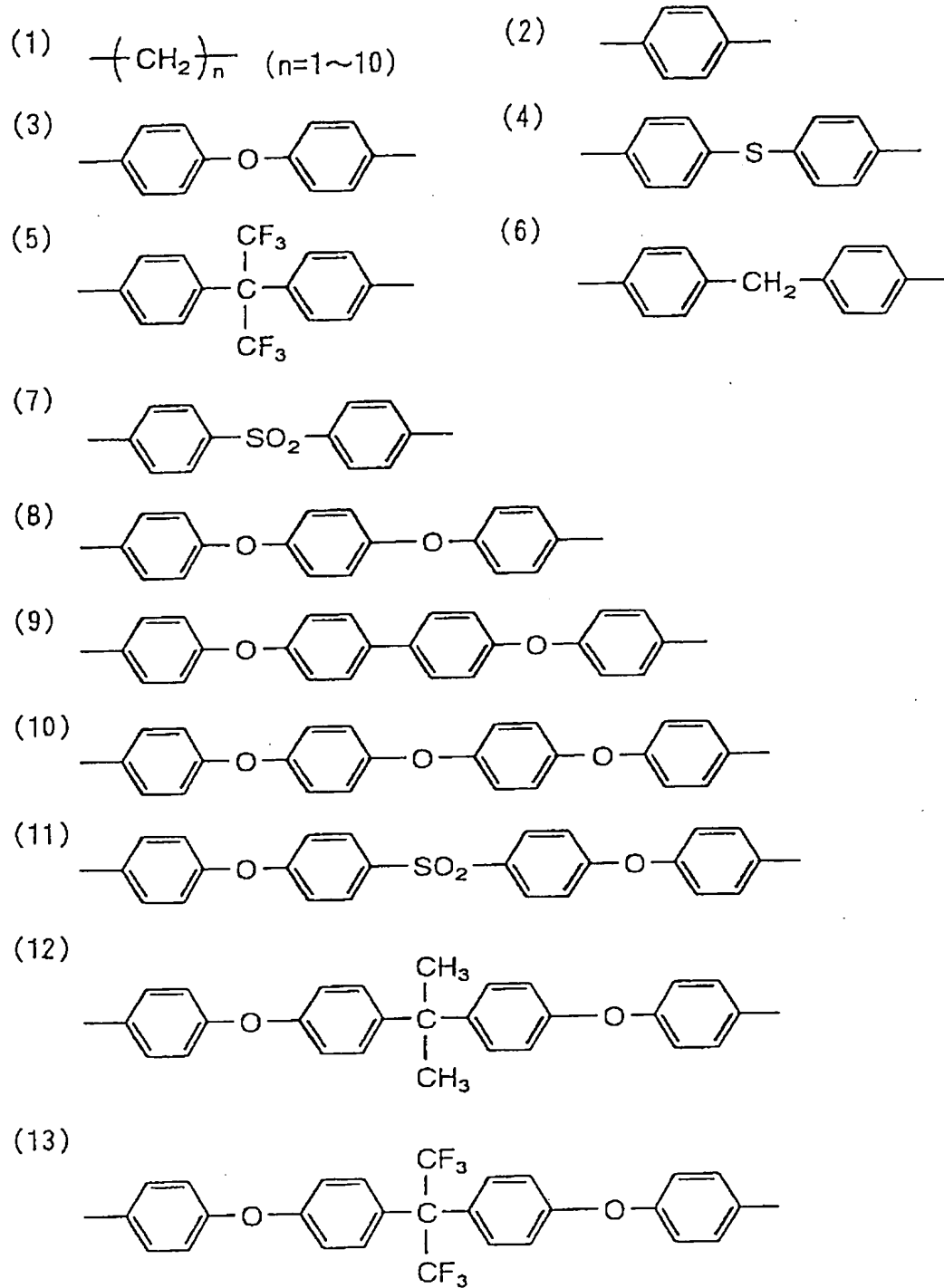
the invention is represented by formula (I):



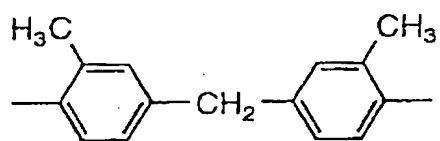
wherein R represents a divalent linking group; and n represents an integer of 10 to 100.

In formula (I), the divalent linking group as represented by R may be aliphatic or aromatic. Examples of suitable linking

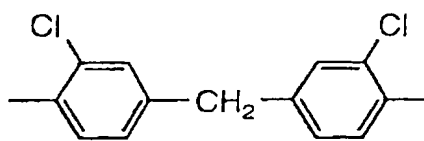
10 groups R are shown below.



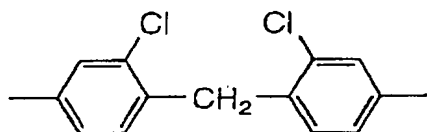
(14)



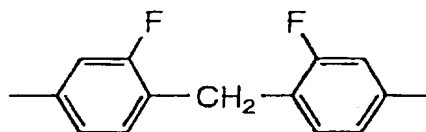
(15)



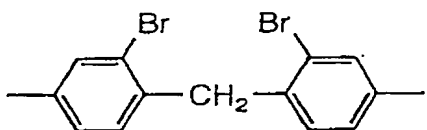
(16)



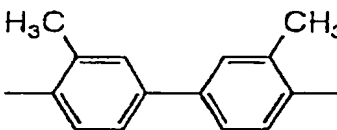
(17)



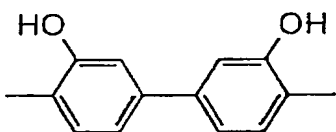
(18)



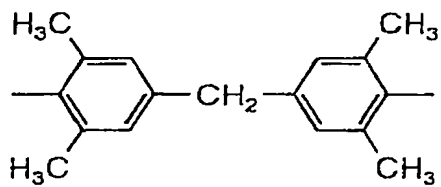
(19)



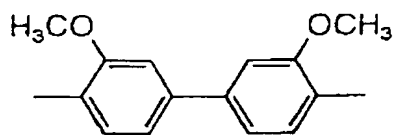
(20)



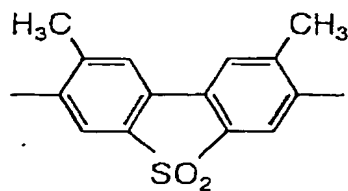
(21)



(22)



(23)

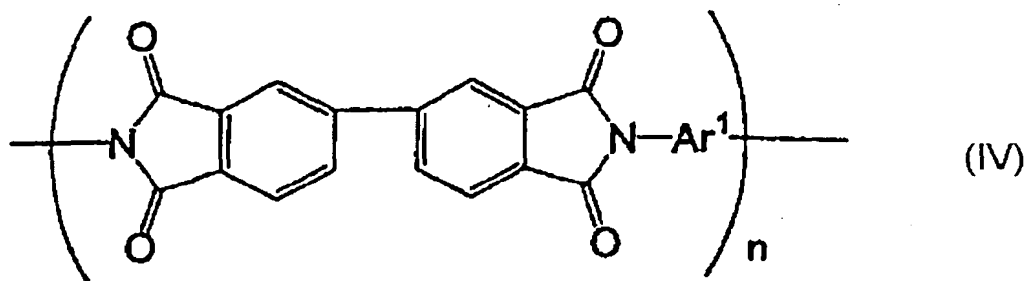
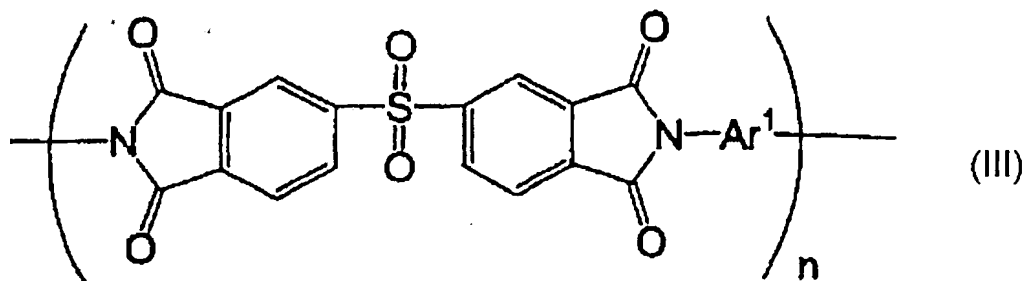


Preferred of them are linking groups (6), (7), (11), and (14). The linking groups listed above may be used either alone or in the form of a combination of two or more thereof.

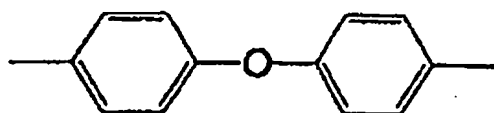
The polyamide-imide represented by formula (I) preferably
5 has a number average molecular weight of 3000 to 50000, particularly 10000 to 25000.

The polyamide-imide resin of formula (I) can be used in combination with other binders having the above-mentioned preferred physical properties. Useful other binders include
10 acrylic resins, e.g., polymethyl methacrylate; polycarbonate; vinyl resins, e.g., polystyrene, vinyl chloride-vinyl acetate copolymers, and polyvinyl alcohol; polyvinyl butyral, polyester, polyvinyl chloride, polyamide, polyimide, polyether imide, polysulfone, polyether sulfone, aramid, polyurethane,
15 epoxy resins, and urea-melamine resins. Polyimide resins are especially preferred of them.

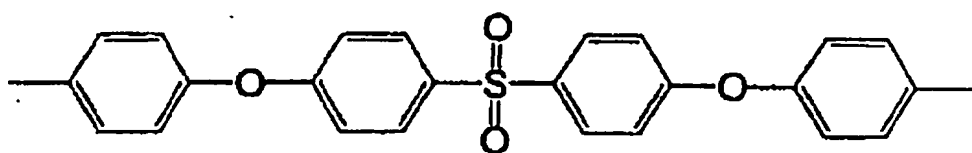
In particular, polyimide resins represented by formulae (III) to (IX), being soluble in organic solvents, are preferably used in combination with the polyamide-imide resin of formula
20 (I) to improve the productivity of the heat transfer sheet. These polyimide resins are also preferred for obtaining improvements on viscosity stability, long-term preservability and moisture resistance of a coating composition for heat-light conversion layer.



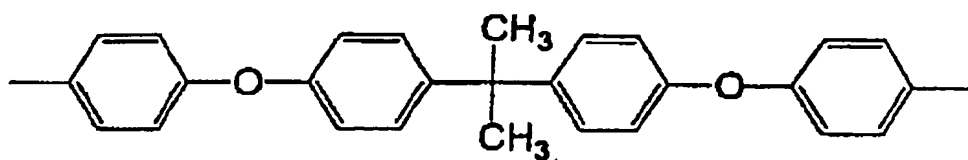
10 In formulae (III) and (IV), Ar^1 represents an aromatic group represented by structural formulae (1) to (3); and n represents an integer of 10 to 100.



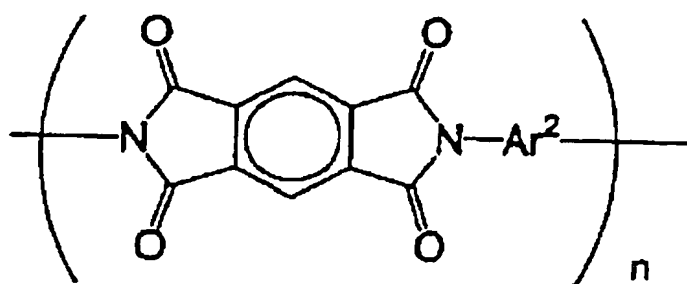
(1)



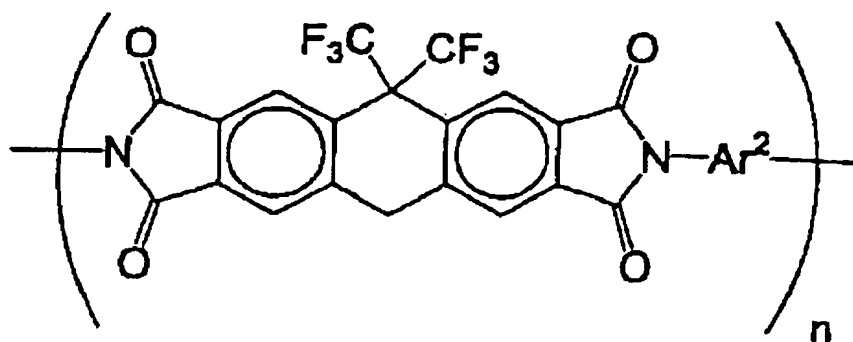
(2)



(3)

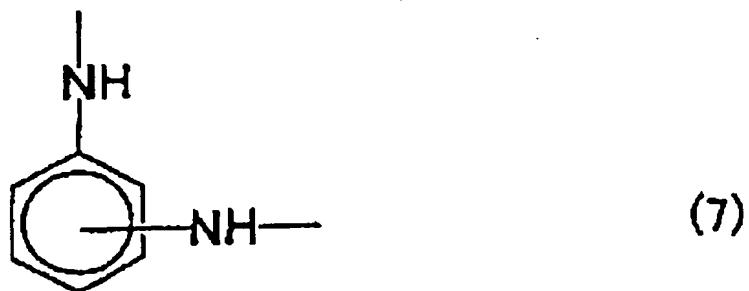
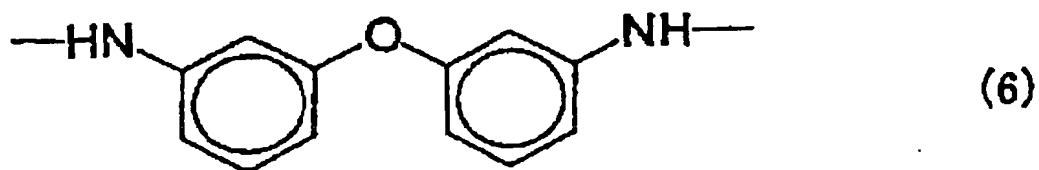
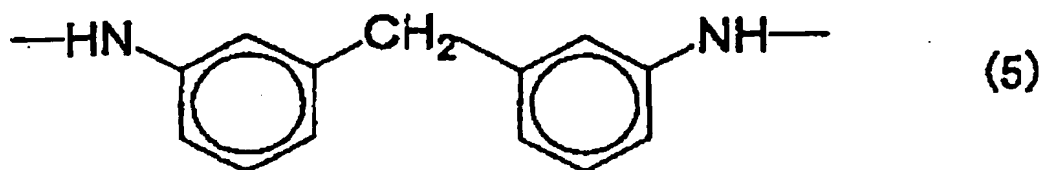
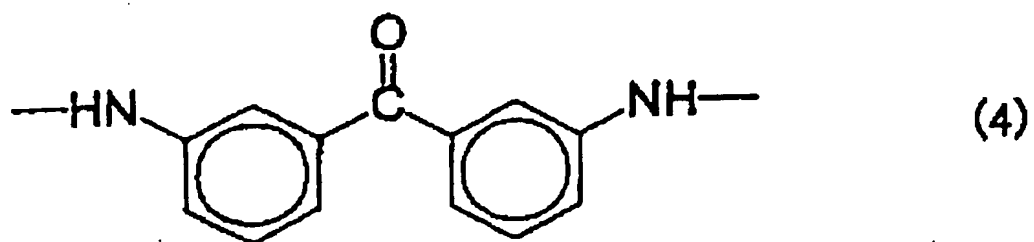


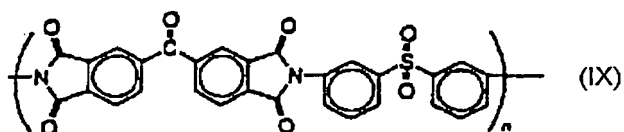
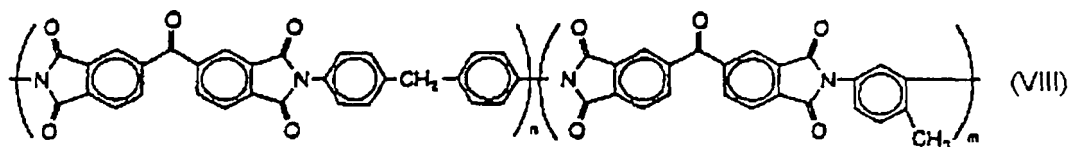
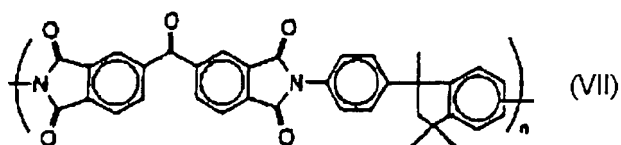
(V)



(VI)

In formulae (V) and (VI), Ar^2 represents an aromatic group represented by structural formulae (4) to (7); and n represents an integer of 10 to 100.





In formulae (VII) to (IX), n and m each represent an integer of 10 to 100. In formula (VIII), the ratio n/m is 6/4 to 9/1.

The polyamide-imide represented by formula (I) is preferably used in a proportion of 50 to 100% by weight, particularly 70 to 100% by weight, based on the total binder in the light-heat conversion layer.

When at least 10 parts by weight of a binder resin dissolves in 100 parts by weight of N-methylpyrrolidone at 25°C, the resin can be seen as soluble in organic solvents. Resins soluble in organic solvents are preferably used as a binder of the light-heat conversion layer. Resins having a solubility of 100 parts by weight or more in 100 parts by weight of N-methylpyrrolidone are still preferred.

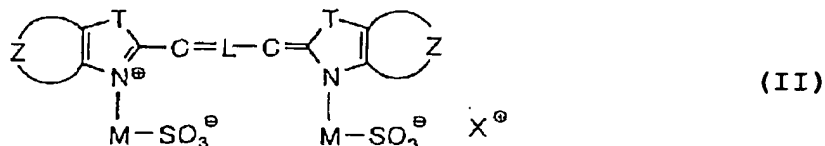
The light-heat converting substance used in the

light-heat conversion layer is a substance capable of converting light energy to heat energy when irradiated with light. This substance is generally a colorant (inclusive of a dye and a pigment) capable of absorbing laser light. In infrared laser recording, infrared absorbing colorants are preferably used. Useful infrared absorbing colorants include black pigments, e.g., carbon black; macrocyclic compound pigments showing absorption in the visible to near-infrared region, such as phthalocyanine pigments and naphthalocyanine pigments; organic dyes used in high-density laser recording media (e.g., optical disks), such as cyanine dyes (e.g., indolenine dyes), anthraquinone dyes, azulene dyes, and phthalocyanine dyes; and organometallic colorants, such as dithiol nickel complexes. *Inter alia*, cyanine dyes have a high absorptivity coefficient in the infrared region. Use of the cyanine dyes as a light-heat converting substance makes it feasible to reduce the thickness of the light-heat conversion layer, which leads to improved recording sensitivity of the heat transfer sheet.

Useful light-heat converting substances include not only the colorants but inorganic materials such as particulate metallic materials, e.g., blackened silver.

Of the above-recited light-heat converting substances preferred are compounds represented by formula (II) shown below in view of their high heat resistance and stability with time against decomposition, i.e., stability against reduction in

absorbance in a coating composition.



wherein Z represents an atomic group necessary to form a benzene ring, a naphthalene ring or a heterocyclic aromatic ring; T represents -O-, -S-, -Se-, -N(R¹)-, -C(R²)(R³)- or -C(R⁴)=C(R⁵)-; R¹, R², and R³ each represent an alkyl group, an alkenyl group or an aryl group; R⁴ and R⁵ each represent a hydrogen atom, a halogen atom, an alkyl group, an aryl group, an alkoxy group, an aryloxy group, a carboxyl group, an acyl group, an acylamino group, a carbamoyl group, a sulfamoyl group or a sulfonamido group; L represents a trivalent linking group consisting of conjugated 5 or 7 methine groups; M represents a divalent linking group; and X⁺ represents a cation.

The heterocyclic aromatic ring formed by Z includes a pyridine ring, a quinoline ring, a pyrazine ring, and a quinoxaline ring. The atomic group Z may have a substituent R⁶, such as an alkyl group, an aryl group, a heterocyclic group, a halogen atom, an alkoxy group, an aryloxy group, an alkylthio group, an arylthio group, an alkylcarbonyl group, an arylcarbonyl group, an alkyloxycarbonyl group, an aryloxycarbonyl group, an alkylcarbonyloxy group, an arylcarbonyloxy group, an alkylamido group, an arylamido group,

an alkylcarbamoyl group, an arylcarbamoyl group, an alkylamino group, an arylamino group, a carboxyl group, an alkylsulfonyl group, an arylsulfonyl group, an alkylsulfonamido group, an arylsulfonamido group, an alkylsulfamoyl group, an arylsulfamoyl group, a cyano group, and a nitro group. The number of the substituents R^6 that are possessed by Z is usually up to about 4. Where there are two or more substituents R^6 , they may be the same or different.

Preferred substituents R^6 include a halogen atom (e.g., F or Cl), a cyano group, a substituted or unsubstituted alkoxy group having 1 to 20 carbon atoms (e.g., methoxy, ethoxy, dodecyloxy or methoxyethoxy), a substituted or unsubstituted phenoxy group having 6 to 20 carbon atoms (e.g., phenoxy, 3,5-dichlorophenoxy or 2,4-di-*t*-pentylphenoxy), a substituted or unsubstituted alkyl group having 1 to 20 carbon atoms (e.g., methyl, ethyl, isobutyl, *t*-pentyl, octadecyl or cyclohexyl), and a substituted or unsubstituted phenyl group having 6 to 20 carbon atoms (e.g., phenyl, 4-methylphenyl, 4-trifluoromethylphenyl or 3,5-dichlorophenyl).

In formula (II), T represents $-O-$, $-S-$, $-Se-$, $-N(R^1)-$, $-C(R^2)(R^3)-$ or $-C(R^4)=C(R^5)-$, wherein R^1 , R^2 , R^3 , R^4 , and R^5 each preferably represent a substituted or unsubstituted alkyl group, a substituted or unsubstituted aryl group or a substituted or unsubstituted alkenyl group, with an alkyl group being still preferred. The group represented by R^1 , R^2 , R^3 , R^4 , and R^5

preferably contains 1 to 30 carbon atoms, particularly 1 to 20 carbon atoms.

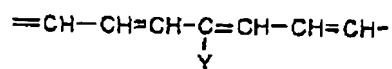
Substituents the groups R^1 , R^2 , R^3 , R^4 , and R^5 may have preferably include a sulfonic acid group, an alkylcarbonyloxy group, an alkylamido group, an alkylsulfonamido group, an alkoxy carbonyl group, an alkylamino group, an alkylcarbamoyl group, an alkylsulfamoyle group, an alkoxy group, an aryloxy group, an alkylthio group, an arylthio group, an alkyl group, an aryl group, a carboxyl group, a halogen atom, and a cyano group.

Still preferred among these substituents are a halogen atom (e.g., F or Cl), a cyano group, a substituted or unsubstituted alkoxy group having 1 to 20 carbon atoms (e.g., methoxy, ethoxy, dodecyloxy or methoxyethoxy), a substituted or unsubstituted phenoxy group having 6 to 20 carbon atoms (e.g., phenoxy, 3,5-di-chlorophenoxy or 2,4-di-t-pentylphenoxy), a substituted or unsubstituted alkyl group having 1 to 20 carbon atoms (e.g., methyl, ethyl, isobutyl, t-pentyl, octadecyl or cyclohexyl), and a substituted or unsubstituted phenyl group having 6 to 20 carbon atoms (e.g., phenyl, 4-methylphenyl, 4-trifluoromethylphenyl or 3,5-dichlorophenyl). R^1 , R^2 , R^3 , R^4 , and R^5 each particularly preferably represent an unsubstituted alkyl group having 1 to 8 carbon atoms. T is most preferably $-C(CH_3)_2-$.

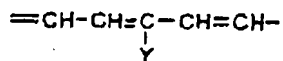
In formula (II), L represents a trivalent linking group

consisting of 5 or 7 conjugated methine groups (i.e., a pentamethine group or a heptamethine group), which may be substituted or unsubstituted. Preferred linking groups L are shown below.

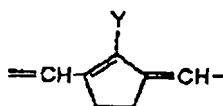
(L - 1)



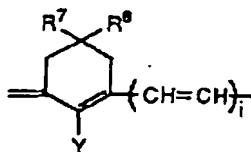
(L - 2)



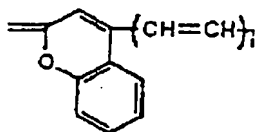
(L - 3)



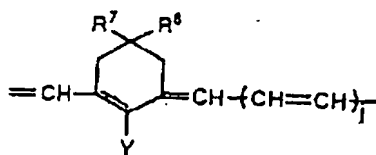
(L - 4)



(L - 5)



(L - 6)



wherein Y represents a hydrogen atom or a substituent; i represents 1 or 2; and j represents 0 or 1.

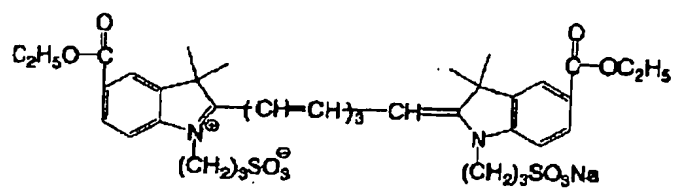
Particularly preferred linking groups are those forming a tricarbo-cyanine group, i.e., (L-2), (L-3), (L-4), (L-5), and
5 (L-6). In the linking groups (L-1) to (L-6) illustrated above, suitable substituents as represented by Y include a lower alkyl group (e.g., methyl), a lower alkoxy group (e.g., methoxy), a substituted amino group (e.g., dimethylamino, diphenylamino, methylphenylamino, morpholino, imidazolidinyl or
10 ethoxycarbonylpiperazinyl), an alkylcarbonyloxy group (e.g., acetoxy), an alkylthio group (e.g., methylthio), a cyano group, a nitro group, and a halogen atom (e.g., Br, Cl or F).

Y is preferably a hydrogen atom. R^7 and R^8 each preferably represent a hydrogen atom or a lower alkyl group (e.g.,
15 methyl) (more preferably, the lower alkyl group has 5 or less carbon atoms).

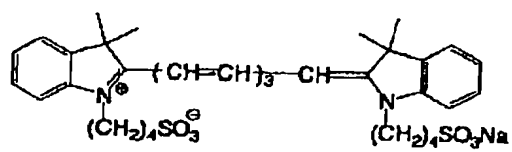
In formula (II), M is preferably a substituted or unsubstituted alkylene group having 1 to 2 carbon atoms, e.g., ethylene, propylene or butylene. The cation as represented
20 by X^+ includes a metal ion (e.g., Na^+ or K^+), an ammonium ion (e.g., $HN^+(C_2H_5)_3$), and a pyridinium ion.

Specific examples of the compounds represented by formula (II) are shown below for illustrative purposes only but not for limitation.

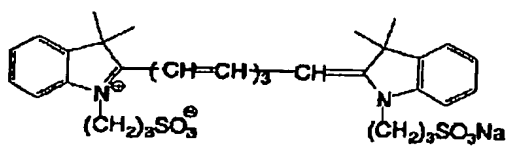
(1-1)



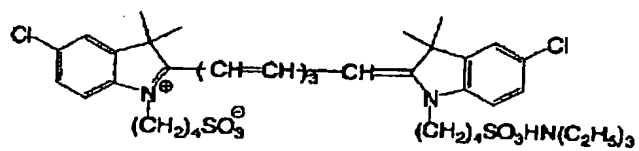
(1-2)



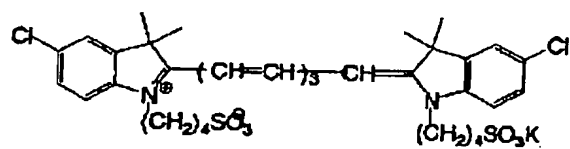
(1-3)



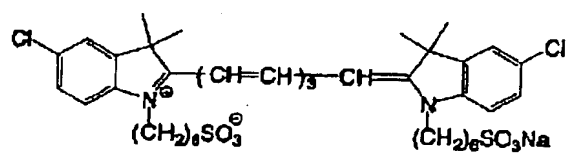
(1-4)



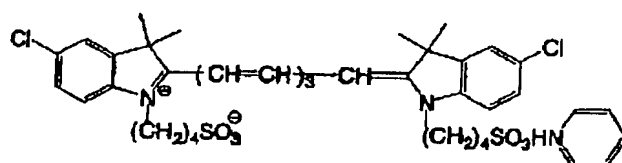
(1-5)



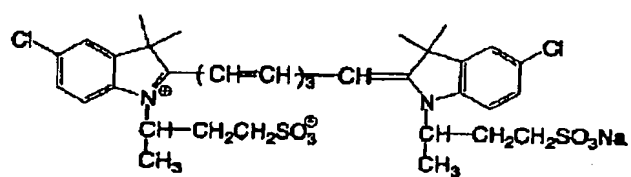
(1-6)



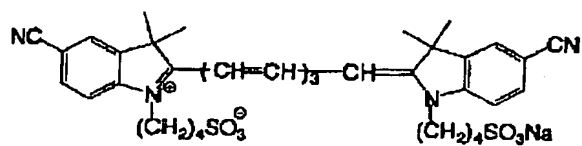
(1-7)



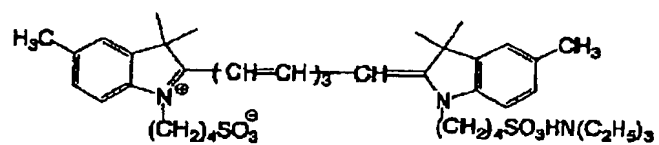
(1-8)



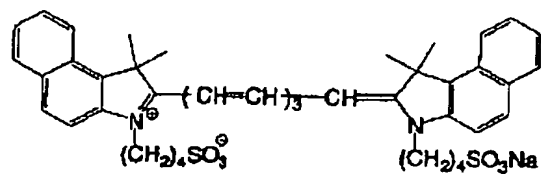
(1-9)



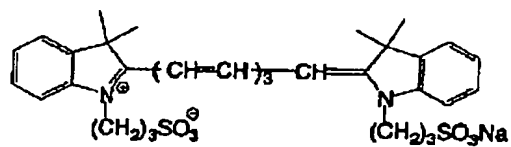
(1-10)



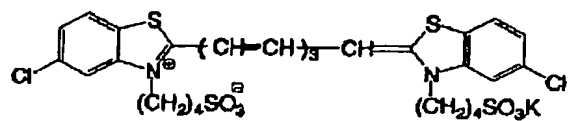
(1-11)



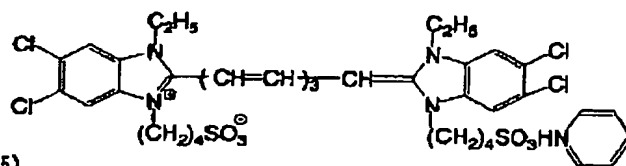
(1-12)



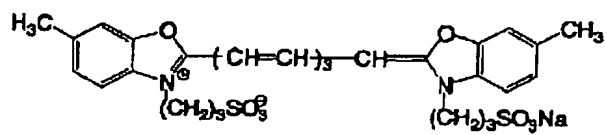
(1-13)



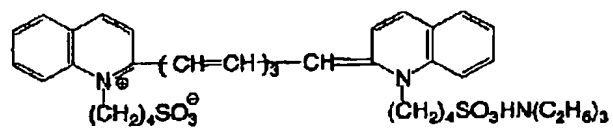
(1-14)



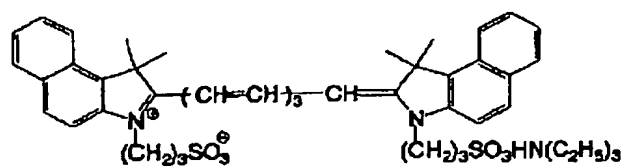
(1-15)



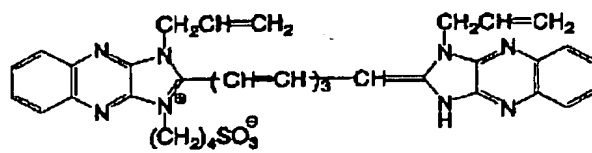
(1-16)



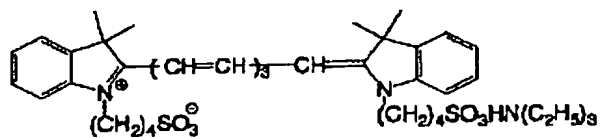
(1-17)



(1-18)



(1-19)



The compounds of formula (II) are generally easily synthesized in the same manner as for other carbocyanine dyes by reacting a heterocyclic enamine with an acetal, e.g., $\text{CH}_3\text{O}-\text{CH}=\text{CH}-\text{CH}=\text{CH}-\text{CH}(\text{OCH}_3)_2$, a compound represented by
5 $\text{PhN}-\text{CH}-(\text{CH}-\text{CH})-\text{NHPh}$ (where Ph represents phenyl), etc. For the detail, JP-A-5-116450 can be referred to.

It is preferred that the light-heat converting substance has a decomposition temperature of 200°C or higher, particularly 250°C or higher. A high decomposition temperature eliminates
10 fogging due to coloring with decomposition products. Light-heat converting substances whose decomposition temperature is lower than 200°C can decompose on laser recording, and the decomposition products can reduce the transfer image quality.

15 While it is desirable that the light-heat conversion layer contain the compound of formula (II) as a main light-heat converting substance, known light-heat converting substances may be used in combination in an amount that does not impair the effects of the invention. The known light-heat converting
20 substances are generally colorants (inclusive of dyes and pigments) capable of absorbing laser light. Such colorants include black pigments, e.g., carbon black; macrocyclic compound pigments showing absorption in the visible to near-infrared region, such as phthalocyanine pigments and
25 naphthalocyanine pigments; organic dyes used in high-density

laser recording media (e.g., optical disks), such as cyanine dyes other than the indolenine dyes of formula (II), anthraquinone dyes, azulene dyes, and phthalocyanine dyes; and organometallic colorants, such as dithiol nickel complexes.

5 The matting agents which can be added to the light-heat conversion layer include inorganic fine particles and organic fine particles. The inorganic fine particles include metal oxides, e.g., silica, titanium oxide, aluminum oxide, zinc oxide, and magnesium oxide, metal salts, e.g., barium sulfate,
10 magnesium sulfate, aluminum hydroxide, magnesium hydroxide, and boron nitride, kaolin, clay, talc, zinc flower, lead white, zeeklite, quartz, diatomaceous earth, pearlite, bentonite, mica, and synthetic mica. The organic fine particles include particles of fluorine resins, guanamine resins, acrylic resins,
15 styrene-acryl copolymer resins, silicone resins, melamine resins, and epoxy resins.

The matting agent generally has a particle size of 0.3 to 30 μm , preferably 0.5 to 20 μm . It is preferably added in an amount of 0.1 to 100 mg/m^2 .

20 If desired, the light-heat conversion layer can contain surface active agents, thickeners, antistatic agents, and the like.

The light-heat conversion layer is formed by applying a coating composition to a substrate and drying the coating.

25 The coating composition is prepared by dissolving the light-heat

converting substance and a binder in an organic solvent and adding thereto a matting agent and other necessary components. Organic solvents which can be used to dissolve the binder comprising the polyamide-imide resin include n-hexane, cyclohexane, diglyme, xylene, toluene, ethyl acetate, tetrahydrofuran, methyl ethyl ketone, acetone, cyclohexanone, 1,4-dioxane, 1,3-dioxane, dimethyl acetate, N-methyl-2-pyrrolidone, dimethyl sulfoxide, dimethylformamide, dimethylacetamide, γ -butyrolactone, ethanol, and methanol. Application and drying of the coating composition can be carried out in a conventional manner. Drying is usually effected at temperatures of 300°C or lower, preferably 200°C or lower. Where a polyethylene terephthalate substrate is used, drying is preferably performed at 80 to 150°C.

Where the amount of the binder in the light-heat conversion layer is too small, the light-heat conversion layer has reduced cohesion and tends to accompany the image forming layer being transferred to the image receiving sheet, which causes image color mixing. Use of too much binder necessitates an increase in layer thickness for achieving a given absorbance, which can invite sensitivity reduction. A preferred solid basis weight ratio of the light-heat converting substance to the binder in the light-heat conversion layer is 1:20 to 2:1, particularly 1:10 to 2:1. The light-heat conversion layer preferably has an absorbance of 70 to 95%, particularly 90 to 95%.

As the light-heat conversion layer becomes thinner, the transfer sensitivity increases as stated previously. The thickness of the light-heat conversion layer is preferably 0.03 to 1.0 μm , still preferably 0.05 to 0.5 μm . From the standpoint of transfer sensitivity, the optical density of the light-heat conversion layer is preferably 0.80 to 1.26, still preferably 0.92 to 1.15, at a wavelength of 808 nm. If the optical density at a laser peak wavelength is less than 0.80, light to heat conversion would be insufficient, resulting in reduced transfer sensitivity. An optical density exceeding 1.26 will adversely affect the recording function of the light-heat conversion layer, which can result in fogging.

In what follows, the image forming layer of the heat transfer sheet (A) is designated "image forming layer (A)", and that of the heat transfer sheet (B) "image forming layer (B)". The simple expression "image forming layer" is intended to include both image forming layers (A) and (B).

The image forming layer (A) preferably has a gloss of 1.2 or greater, particularly 1.2 to 4, especially 1.5 to 3. The image forming layer (B) preferably has a gloss smaller than 1.2. The gloss is measured as follows.

Measurement of gloss:

Measurement was made with a spectrophotometer for gloss measurement (CM-512m3 available from Minolta Co., Ltd.). A sample is illuminated with a xenon light pulse at an angle of

incidence of 25° and 75° from the vertical, and the sensor receives light reflected at an angle of reflection of 45° to obtain the CIE L* value. The gloss is defined to be the ratio of the L* value at an incidence angle of 25° to the L* value at an incidence
5 angle of 75°, L^*_{25}/L^*_{75} .

The image forming layer (A) contains at least one luster pigment selected from tabular inorganic compound particles and metal particles and is lustrous owing to the luster pigment. The metal particles includes those of aluminum, gold, silver,
10 copper, zinc, etc. Aluminum particles are the most advantageous for luster and cost. The metal particles preferably have a particle size of 0.05 to 7 μm , particularly 0.1 to 3 μm .

The tabular inorganic compound particles include pearl pigments comprising natural pearl essence, mercury chloride,
15 basic lead carbonate, bismuth oxychloride or mica powder. Mica powder-based pearl pigments are the most suitable of them for safety and cost. Mica powder coated with titanium dioxide is preferred. Mica powder coated with iron oxide provides a pearl pigment with a tint different from titanium dioxide-coated mica
20 powder. The tabular inorganic compound particles preferably have a thickness of 0.1 to 0.7 μm , a particle size of 2 to 30 μm , and an aspect ratio of 1.2 to 4, still preferably have a thickness of 0.2 to 0.7 μm , a particle size of 5 to 25 μm , and an aspect ratio of 1.5 to 3. Where the thickness exceeds 0.7 μm , the
25 effect of light interference is lessened by reflection on the

mice/titanium dioxide interference, resulting in reduction of luster. Particle sizes of 1 μm or smaller result in reduction of gloss. Particles greater than 50 μm impair surface smoothness and fail to provide a uniform luster.

5 The luster pigment content in the image forming layer (A) is preferably 10 to 70% by weight, still preferably 15 to 40% by weight. The tabular inorganic compound particles are preferably dispersed in the image forming layer (A) with their main planes in almost parallel to the substrate plane so that
10 the image forming layer (A) may have reduced surface roughness and improved adhesion to an image receiving sheet, which brings about improved transfer image quality. Such a dispersed state of the tabular particles can be obtained by controlling the shearing force in applying the coating composition containing
15 the tabular particles.

 The transparent colorants that can be used in the image forming layer (B) are roughly divided into organic pigments and inorganic pigments. The former is particularly excellent in film transparency, and the latter is generally excellent
20 in hiding powder. Proper pigments are selected according to the purpose with these characteristics taken into consideration. In making heat transfer sheets for color proofing, it is preferred to use organic pigments whose color tones match or approximate the colors of printing inks, such as yellow, magenta,
25 cyan, black, red, green, blue, and orange. Metallic powders,

fluorescent pigments, and the like are also used in some cases. Suitable pigments include azo pigments, phthalocyanine pigments, anthraquinone pigments, dioxazine pigments, quinacridone pigments, isoindolinone pigments, and nitro
5 pigments. The pigments useful in the image-forming layer (B) are listed below for illustrative purposes only but not for limitation.

1) Yellow pigment

Pigment Yellow 12 (C.I. No. 21090):

10 Example: Permanent Yellow DHG (from Clariant (Japan) KK),
Lionol Yellow 1212B (from Toyo Ink Mfg. Co., Ltd.),
Irgalite Yellow LCT (from Ciba Specialty Chemicals),
Symuler Fast Yellow GTF 219 (from Dainippon Ink & Chemicals,
Inc.)

15 Pigment Yellow 13 (C.I. No. 21100):

Example: Permanent Yellow GR (from Clariant (Japan) KK),
Lionol Yellow 1313 (from Toyo Ink Mfg. Co., Ltd.)

Pigment Yellow 14 (C.I. No. 21095):

20 Example: Permanent Yellow G (from Clariant (Japan) KK),
Lionol Yellow 1401-G (from Toyo Ink Mfg. Co., Ltd.), Seika
Fast Yellow 2270 (from Dainichiseika Colour & Chemicals
Mfg. Co., Ltd.), Symuler Fast Yellow 4400 (from Dainippon
Ink & Chemicals, Inc.)

Pigment Yellow 17 (C.I. No. 21105):

25 Example: Permanent Yellow GG02 (from Clariant (Japan)

KK), Symuler Fast Yellow 8GF (from Dainippon Ink & Chemicals, Inc.)

Pigment Yellow 155:

Example: Graphtol Yellow 3GP (from Clariant (Japan) KK)

5 Pigment Yellow 180 (C.I. No. 21290):

Example: Novoperm Yellow P-HG (from Clariant (Japan) KK.),

PV Fast Yellow HG (from Clariant (Japan) KK.)

Pigment Yellow 139 (C.I. No. 56298):

Example: Novoperm Yellow M2R 70 (from Clariant (Japan)

10 KK.)

2) Magenta Pigment

Pigment Red 57:1 (C.I. No. 15850:1):

Example: Graphtol Rubine L6B (from Clariant (Japan) KK),

Lionol Red 6B-4290G (from Toyo Ink Mfg. Co., Ltd.),

15 Irgalite Rubine 4BL (from Ciba Specialty Chemicals),

Symuler Brilliant Carmine 6B-229 (from Dainippon Ink & Chemicals, Inc.)

Pigment Red 122 (C.I. No. 73915):

Example: Hosterperm Pink E (from Clariant (Japan) KK.),

20 Lionogen Magenta 5790 (from Toyo Ink Mfg. Co., Ltd.),

Fastogen Super Magenta RH (from Dainippon Ink & Chemicals, Inc.)

Pigment Red 53:1 (C.I. No. 15585:1):

Example: Permanent Lake Red LCY (from Clariant (Japan)

25 KK), Symuler Lake Red C conc (from Dainippon Ink & Chemicals,

Inc.)

Pigment Red 48:2 (C.I. No. 15865:2):

Example: Permanent Red W2T (from Clariant (Japan) KK),
Lionol Red LX235 (from Toyo Ink Mfg. Co., Ltd.), Symuler
5 Red 3012 (from Dainippon Ink & Chemicals, Inc.)

Pigment Red 177 (C.I. No. 65300):

Example: Cromophtal Red A2B (from Ciba Specialty
Chemicals)

3) Cyan Pigment

10 Pigment Blue 15 (C.I. No. 74160):

Example: Lionol Blue 7027 (from Toyo Ink Mfg. Co., Ltd.),
Fastogen Blue BB (from Dainippon Ink & Chemicals, Inc.)

Pigment Blue 15:1 (C.I. No. 74160):

Example: Hosterperm Blue A2R (from Clariant (Japan) KK),
15 Fastogen Blue 5050 (from Dainippon Ink & Chemicals, Inc.)

Pigment Blue 15:2 (C.I. No. 74160):

Example: Hosterperm Blue AFL (from Clariant (Japan) KK),
Irgalite Blue BSP (from Ciba Specialty Chemicals),
Fastogen Blue GP (from Dainippon Ink & Chemicals, Inc.)

20 Pigment Blue 15:3 (C.I. No. 74160):

Example: Hosterperm Blue B2G (from Clariant (Japan) KK.),
Lionol Blue FG7330 (from Toyo Ink Mfg. Co., Ltd.),
Cromophtal Blue 4GNP (from Ciba Specialty Chemicals),
Fastogen Blue FGF (from Dainippon Ink & Chemicals, Inc.)

25 Pigment Blue 15:4 (C.I. No. 74160):

Example: Hosterperm Blue BFL (from Clariant (Japan) KK),
Cyanine Blue 700-10FG (from Toyo Ink Mfg. Co., Ltd.),
Irgalite Blue GLNF (from Ciba Specialty Chemicals),
Fastogen Blue FGS (from Dainippon Ink & Chemicals, Inc.)

5 4) Black Pigment

Pigment Black 7 (carbon black C.I. No. 77266):

Example: Mitsubishi Carbon Black MA100 (from Mitsubishi
Chemicals Co., Ltd.), Mitsubishi Carbon Black #5 (from
Mitsubishi Chemicals Co., Ltd.), Black Pearls 430 (from
10 Cabot Co.)

The pigments to be used in the invention can be chosen
from commercially available products by referring to Nippon
Ganryo Gijutsu Kyokai (ed.), *Ganryo Binran*, Seibundo Shinko-Sha
(1989), and *COLOUR INDEX, THE SOCIETY OF DYES & COLOURIST*, 3rd
15 Ed. (1987).

The pigments preferably have an average particle size
of 0.03 to 1 μm , particularly 0.05 to 0.5 μm . Where the average
particle size is smaller than 0.03 μm , pigment dispersing cost
tends to increase, and dispersions tend to gel. As far as the
20 average particle size is 1 μm or smaller, there is no coarse
particles, which assures good adhesion between the image forming
layer (B) and the image receiving layer and improves the
transparency of the image forming layer (B).

The pigment content in the image forming layer (B) is
25 preferably 30 to 70% by weight, still preferably 30 to 50% by

weight.

The binder to be used in the image forming layer preferably includes amorphous organic polymers having a softening point of 40 to 150°C. Such polymers include butyral resins, polyamide
5 resins, polyethylene-imine resins, sulfonamide resins, polyesterpolyol resins, petroleum resins; homo- and copolymers of styrene or derivatives thereof, e.g., styrene, vinyltoluene, α -methylstyrene, 2-methylstyrene, chlorostyrene, vinylbenzoic acid, sodium vinylbenzenesulfonate, and
10 aminostyrene; and homo- and copolymers of vinyl compounds, such as methacrylic acid and esters thereof, e.g., methyl methacrylate, ethyl methacrylate, butyl methacrylate, and hydroxyethyl methacrylate, acrylic acid and esters thereof, e.g., methyl acrylate, ethyl acrylate, butyl acrylate, and
15 α -ethylhexyl acrylate, dienes, e.g., butadiene and isoprene, acrylonitrile, vinyl ethers, maleic acid, maleic esters, maleic anhydride, cinnamic acid, vinyl chloride, and vinyl acetate. These resins may be used either individually or as a mixture thereof.

20 The image forming layer preferably contains 30 to 70% by weight, particularly 40 to 70% by weight, of the binder resin.

The image forming layer (A) contains a thixotropic agent. The thixotropic agent is a compound which develops thixotropy in a dispersion of pigment particles having a large particle
25 size or a large specific gravity like the luster pigments of

the image forming layer (A) thereby to help the particles maintain the dispersed state. When added to a dispersion containing the luster pigment, the thixotropic agent allows the dispersion to gain high viscosity in a still state thereby preventing sedimentation of the pigment particles. On applying shearing force to the dispersion, the dispersion drastically reduces in viscosity and becomes filterable or easily applicable to a substrate to give a uniform coating thickness. Accordingly, it is preferred for the thixotropic agent to have higher thixotropy for securing higher stability and more uniformity of the dispersion, which will provide an image forming layer having a uniform pigment content in a stable manner.

It is known that thixotropic agents developing the above-described thixotropy often precipitate partially to form a three-dimensional network structure in a dispersion. The thixotropic agents which can be added to the image forming layer (A) are preferably selected from those which precipitate into needle-like or sheet crystals, such as polyamide waxes, metallic soaps, organic bentonite, polyethylene oxide compounds, and hydrogenated castor oil wax. Inorganic fine particles such as silicon dioxide fine particles are also effective thixotropic agents. Of these compounds, polyamide waxes, polyethylene oxide compounds, and metallic soaps are especially preferred.

The polyamide waxes include amides of fatty acids, e.g., stearic acid, behenic acid, myristic acid, lauric acid, and

palmitic acid. Fatty acid amides containing two or more amido groups per molecule are preferred to monoamides for their high thixotropy. The metallic soaps include metal salts of stearic acid, palmitic acid, etc. The metal of the metal soaps preferably includes aluminum, calcium, and magnesium.

The thixotropic agent except polyethylene oxide compounds is preferably added in an amount of 0.01 to 0.3 part by weight per part by weight of the luster pigment. Less than 0.01 part of the thixotropic agent tends to be insufficient for developing an anti-sedimentation effect and maintaining a uniform dispersed state of the luster pigment. Addition of more than 0.3 part of the thixotropic agent tends to result in too much precipitation in the image forming layer (A), which can cause image defects.

The polyoxyethylene compound as a thixotropic agent preferably has a molecular weight of 300 to 50000. It is preferably added in an amount of 0.02 to 0.4 part by weight per part by weight of the luster pigment. Less than 0.02 part of the polyoxyethylene compound tends to be insufficient for developing an anti-sedimentation effect and maintaining a uniform dispersed state of the luster pigment. Addition of more than 0.4 part of the polyoxyethylene compound can cause image defects. The above-recited thixotropic agents can be used either individually or as a combination of two or more thereof.

Even where a low viscosity is required of a coating composition containing large or heavy pigment particles, use of the thixotropic agent helps the pigment particles be dispersed uniformly and kept dispersed stably and provides a coating film in which the pigment particles are uniformly distributed. Addition of the thixotropic agent also allows the pigment particles be present in an increased concentration. As a result, it is possible to design an image forming layer (A) so as to have increased metallic luster or excellent whiteness. In addition, the coating composition containing the luster pigment and the thixotropic agent can be easily filtered, if necessary, hardly causing filter clogging.

The image forming layer can further contain the following components.

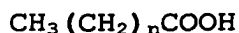
1) Waxes

Useful waxes include mineral waxes, natural waxes and synthetic waxes. Examples of the mineral waxes are petroleum waxes, such as paraffin wax, microcrystalline wax, and ester wax, oxide waxes, montan wax, ozokerite and ceresin. Paraffin wax is preferred above all. The paraffin wax is separated from petroleum, and various products having different melting points are commercially available. The natural waxes include vegetable waxes, e.g., carnauba wax, Japan wax, and esparto wax, and animal waxes, e.g., beeswax, insect wax, shellac wax, and spermaceti.

The synthetic waxes are commonly used as a lubricant and generally comprise higher fatty acid compounds. Included are:

(a) Fatty acid waxes

Straight-chain saturated fatty acids represented by
5 formula:



wherein n is an integer of 6 to 28,

such as stearic acid, behenic acid, palmitic acid,
12-hydroxystearic acid, and azelaic acid; and their metal (e.g.,

10 K, Ca, Zn or Mg) salts.

(b) Fatty Acid Ester Waxes

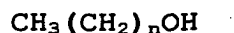
Fatty acid esters, such as ethyl stearate, lauryl stearate,
ethyl behenate, hexyl behenate, and behenyl myristate.

(c) Fatty acid amide waxes

15 Fatty acid amides, such as stearamide and lauramide.

(d) Aliphatic alcohol waxes

Straight-chain saturated aliphatic alcohols represented
by formula:



20 wherein n is an integer of 6 to 28,

such as stearyl alcohol.

Of the synthetic waxes (a) to (d), higher fatty acid amides
such as stearamide and lauramide are suitable. These wax
compounds can be used either alone or in combination thereof.

2) Plasticizers

Suitable plasticizers include known ester compounds. Examples include vinyl compound esters such as acrylic esters and methacrylic esters; phthalic acid esters, e.g., dibutyl phthalate, di-n-octyl phthalate, di(2-ethylhexyl) phthalate, dinonyl phthalate, dilauryl phthalate, butyllauryl phthalate, and butylbenzyl phthalate; aliphatic dibasic acid esters, e.g., di(2-ethylhexyl) adipate, and di(2-ethylhexyl) sebacate; phosphoric triesters, e.g., tricresyl phosphate and tri(2-ethylhexyl) phosphate; polyol polyesters, e.g., polyethylene glycol esters; and epoxy compounds, e.g., epoxy fatty acid esters. Among them, vinyl compound esters, particularly acrylic esters and methacrylic esters are preferred in view of their effects in improving transfer sensitivity, preventing transfer unevenness, and controlling elongation at break. Examples of acrylic and methacrylic esters are polyethylene glycol dimethacrylate, 1,2,4-butanetriol trimethacrylate, trimethylolethane triacrylate, pentaerythritol acrylate, pentaerythritol tetraacrylate, and dipentaerythritol polyacrylate.

Polymeric plasticizers are also useful. Polyesters are preferred polymeric plasticizers because of their high effect of addition and non-diffusibility during storage. Polyester plasticizers include polysebacates and polyadipates.

The plasticizers which can be added to the image forming

layer are not limited to those described. The plasticizers recited above can be used either individually or as a combination of two or more thereof.

Too much additives added to the image forming layer, there
5 would result impaired resolution of a transferred image, reduced strength of the image forming layer, or reduced adhesion between the image forming layer and the light-heat conversion layer. Poor adhesion can result in undesired transfer of a non-exposed area of the image forming layer to an image receiving sheet.
10 From this viewpoint, a recommended wax content in the image forming layer is 0.1 to 30% by weight, preferably 1 to 20% by weight, based on the total solids content of the image forming layer. Likewise, a recommended plasticizer content is 0.1 to 20% by weight, preferably 0.1 to 10% by weight, based on the
15 total solids content of the image forming layer.

(3) Other additives

The image forming layer may further contain other additives, such as surface active agents, organic or inorganic fine particles (metallic powder or silica gel), oils (e.g.,
20 linseed oil and mineral oil), thickeners, and antistatic agents. A substance having an absorption at a writing laser wavelength can be added to the image forming layer except the black image forming layer, which is beneficial for transfer energy saving. While such a substance may be either a pigment or a dye, it
25 is desirable for color reproduction to add a dye having a small

absorption in the visible region and a large absorption at the wavelength of a light source used for recording while using a light source emitting infrared light (e.g., semiconductor laser). Useful near infrared absorbing dyes are described in
5 JP-A-3-103476.

If desired, a wetting dispersant can be added to the image forming layer for improving wettability of the pigment particles with a solvent or a binder thereby accelerating dispersion and minimizing agglomeration of pigment particles. When pigment
10 particles have settled in a dispersion, a wetting dispersant helps the sediment particles re-disperse. Wetting dispersants for pigments include various surface active agents and polycarboxylic acid amine salts. The wetting dispersant is used in an amount of 0.1 to 10% by weight based on the luster
15 pigment.

The above-described heat transfer sheets can be prepared in a usual manner. To form a glossy color image using the heat transfer sheets, the image forming layer (A) comprising the luster pigment and the image forming layer (B) comprising a
20 non-luster colorant are successively heat transferred onto a support for a color image in this order or in the reverse order. The support to which the image forming layers can be transferred includes white paper, other various kinds of paper, resin films, metal sheets, and a glass sheet.

25 The image forming layer can be formed by dissolving or

dispersing the pigment and the binder in a solvent to prepare a coating composition, applying the coating composition on the light-heat conversion layer (or a heat-sensitive release layer if provided on the light-heat conversion layer as described later), and drying the coating. The solvent for use in the preparation of the coating composition includes n-propyl alcohol, methyl ethyl ketone, propylene glycol monomethyl ether, methanol and water. Coating and drying can be performed according to ordinary coating and drying methods.

10 It is preferred to provide a cushioning layer in the heat transfer sheet between the substrate and the image forming layer. A cushioning layer is particularly desirable in the image forming layer containing the luster pigment because the image forming layer is liable to have a rough surface on account of the large particle size of the luster pigment. A cushioning layer is formed of materials having a low elastic modulus, materials having rubbery elasticity or thermoplastic resins ready to soften on heating. The cushioning layer preferably has an elastic modulus of 10 to 500 kgf/cm² or less, particularly 30 to 150 kgf/cm², at room temperature. In order for the cushioning layer to have foreign matter such as dust sinking, the cushioning layer preferably has a penetration of 10 or more as measured according to JIS K2530 (25°C, 100 g, 5 seconds). The cushioning layer preferably has a T_g of 80°C or lower, particularly 25°C or lower. To control these physical properties, such as T_g,

a plasticizer may be added to the polymer binder forming the cushioning layer. Binders making up the cushioning layer include rubbers, such as urethane rubber, butadiene rubber, nitrile rubber, acrylic rubber, and natural rubber, polyethylene, polypropylene, polyester, styrene-butadiene copolymers, ethylene-vinyl acetate copolymers, ethylene-acrylic copolymers, vinyl chloride-vinyl acetate copolymers, vinylidene chloride resins, vinyl chloride resins containing a plasticizer, polyamide resins, and phenol resins.

10 The thickness of the cushioning layer is usually 3 to 100 μm , preferably 10 to 50 μm , while varying depending on the kind of the binder and other conditions.

A heat-sensitive release layer can be provided between the light-heat conversion layer and the image forming layer.

15 The heat-sensitive release layer contains a heat-sensitive material which generates gas or releases adsorption water by the action of the heat generated in the light-heat conversion layer and thereby reduces the adhesive strength between the light-heat conversion layer and the image forming layer. Such
20 a heat-sensitive material includes those compounds, inclusive of polymers and low-molecular compounds, which decompose or denature by heat to generate gas and those compounds, inclusive of polymers and low-molecular compounds, which have absorbed or adsorbed a considerable amount of a volatile compound, such
25 as water. These types of compounds may be used in combination.

Polymers which generate gas on heat decomposition or denaturation include self-oxidizing polymers, e.g., nitrocellulose; halogen-containing polymers, e.g., chlorinated polyolefin, chlorinated rubber, polychlorinated rubber, polyvinyl chloride, and polyvinylidene chloride; acrylic polymers (e.g., polyisobutyl methacrylate) having adsorbed a volatile compound such as water; cellulose esters (e.g., ethyl cellulose) having adsorbed a volatile compound such as water; and natural high molecular compounds (e.g., gelatin) having adsorbed a volatile compound such as water. Low-molecular compounds which generate gas on heat decomposition or denaturation include diazo compounds and azide compounds which generate heat and decompose to generate gas.

It is desirable that decomposition or denaturation of the heat-sensitive material should occur at 280°C or lower, particularly 230°C or lower.

When a low-molecular heat-sensitive material is used in the heat-sensitive release layer, it is preferably used in combination with a binder. The binder to be combined may be either of the type that decomposes or denatures to generate gas or of the type that does not. The weight ratio of the low-molecular heat-sensitive compound to the binder if used is preferably 0.02/1 to 3/1, still preferably 0.05/1 to 2/1. It is preferred that the heat-sensitive release layer be provided on substantially the entire surface of the light-heat conversion

layer. The thickness of the heat-sensitive release layer is usually 0.03 to 1 μm , preferably 0.05 to 0.5 μm .

According to the layer structure having a light-heat conversion layer, a heat-sensitive release layer, and an image forming layer on the substrate in this order, the heat-sensitive release layer decomposes or denatures by heat conducted from the light-heat conversion layer to generate gas. As a result of this decomposition or gas generation, part of the heat-sensitive release layer disappears, or cohesive failure occurs in the heat-sensitive release layer. It follows that the adhesive strength between the light-heat conversion layer and the image forming layer is reduced. Here, depending on the behavior of the heat-sensitive release layer, cases are sometimes met with in which part of the heat-sensitive release layer accompanies the image forming layer transferred to the image receiving sheet, which can cause color mixing in the transfer image. Therefore, it is desirable that the heat-sensitive release layer is substantially colorless so that no perceptible color mixing may occur even if such undesired transfer of the heat-sensitive release layer should happen. In other words, the heat-sensitive release layer should desirably have high transparency to visible rays. Specifically, the absorbance of the heat-sensitive release layer in the visible region is 50% or less, preferably 10% or less.

Instead of providing an independent heat-sensitive

release layer, the above-mentioned light-sensitive material may be incorporated into the light-heat conversion layer so that the light-heat conversion layer may perform the function as a light-heat conversion layer combined with the function
5 as a heat-sensitive release layer.

It is preferred for the heat transfer sheet to have a coefficient of static friction of 0.35 or smaller, particularly 0.20 or smaller, on its surface of the image forming layer side. With this design, the feed rollers for carrying the heat transfer
10 sheets are prevented from being contaminated, and the quality of the transfer image can be improved. The coefficient of static friction is measured in accordance with the method taught in Japanese Patent Application No. 2000-85759, para. [0011].

The image forming layer preferably has a dry thickness
15 of 0.1 to 3 μm , particularly 0.2 to 1.0 μm , a surface roughness R_a of 0.04 to 1.0 μm , particularly 0.06 to 0.3 μm , as measured according to JIS B0601 with, e.g., a profilometer (Surfcom, supplied by Toyo Seiki Co., Ltd.), and a surface hardness of 10 g or more as measured with a sapphire stylus. The static
20 dissipation capability of the image forming layer is preferably such that, when the layer is electrically charged according to Federal Test Standard Method 4046 and then grounded, the electrification potential 1 second after grounding is -100 to 100 V. It is preferred that the surface resistivity of the
25 image forming layer at 23°C and 55% RH be $10^9 \Omega$ or less.

The image forming layer preferably has a smoster value of 4 mmHg or less, particularly 1 mmHg or less. With a smoster value of 4 mmHg or less, the image forming layer is smoothly transferred to the image receiving sheet to give a high quality transfer image. The smoster value represents the amount of air flow, expressed in terms of pressure (mmHg), which varies depending on the surface smoothness of an object to be evaluated. It is measured by making use of a diffused semiconductor pressure transducer. In some detail, a smoster value is measured as follows.

Measurement of smoster value:

A smoster tester comprises a pipe, a vacuum pump connected to one end of the pipe, a measuring head having an area (a_1) connected to the other end of the pipe, and a diaphragm with an aperture area (a_2) disposed between the measuring head and the vacuum pump. The measuring head is brought into contact with the surface of a sample (i.e., the image forming layer of a heat transfer sheet). In this state, the pipe is evacuated by the vacuum pump. The inner pressure (P) between the measuring head and the diaphragm varies with the area ratio a_2/a_1 and is expressed by equation.

$$P = (a_2/a_1)P_z \quad [P_z: \text{atmospheric pressure}]$$

The area a_2 varies according to the sample being measured,

and the pressure P represents the surface smoothness of the sample. The pressure P is a smoofter value. Unless otherwise specified, the smoofter value as referred to in the present invention is the value measured at 23°C and 55% RH with, for
5 example, DIGITAL SMOOSTER DSM-2 supplied by Takenaka Systems.

The image receiving sheet which can be used in combination with the above-described heat transfer sheets (A) and (B) generally comprises a substrate and an image receiving layer. The image receiving sheet may additionally have one or more
10 layers selected from a cushioning layer, a release layer, and an intermediate layer provided between the substrate and the image receiving layer. To secure smooth pass of the image receiving sheet in the recording apparatus, it is preferred to provide a backcoating layer on the back side of the substrate.

15 The substrate of the image receiving sheet includes a resin sheet, a metal sheet, a glass sheet, resin-coated paper, paper, and various composite laminates. Resins which can be used as a substrate include polyethylene terephthalate, polycarbonate, polyethylene, polyvinyl chloride,
20 polyvinylidene chloride, polystyrene, styrene-acrylonitrile copolymers, and polyester. Paper as a substrate includes actual printing paper and coated paper.

It is preferred for the substrate to have micro voids to improve quality of a transfer image. Substrates with micro
25 voids can be obtained by, for example, extruding one or more

molten mixtures of a thermoplastic resin and a filler, such as an inorganic pigment or a polymer incompatible with the thermoplastic resin matrix, into a single-layer or multilayer film and stretching the extruded film uniaxially or biaxially.

5 The void of the resulting stretched film depends on the kinds of the resin and the filler, the mixing ratio, and the stretching conditions.

As a thermoplastic resin matrix, a polyolefin resin, such as polypropylene, or polyethylene terephthalate is preferably
10 used in view of their good crystallinity and stretchability necessary to form voids. A combination of a polyolefin resin or polyethylene terephthalate and a minor proportion of other thermoplastic resin is preferred. The pigment used as a filler preferably has an average particle size of from 1 to 20 μm .
15 Useful pigments are calcium carbonate, clay, diatomaceous earth, titanium oxide, aluminum hydroxide, and silica. In using polypropylene as a thermoplastic resin matrix, polyethylene terephthalate is a preferred filler incompatible with the matrix. For the details of preparation of a substrate with micro voids,
20 reference can be made in JP-A-2001-105752. The content of the filler, such as an inorganic pigment, in the substrate is usually about 2 to 30% by volume.

The thickness of the substrate of the image receiving sheet is usually from 10 to 400 μm , preferably 25 to 200 μm .
25 The substrate may be subjected to surface treatment, e.g., corona

discharge treatment or glow discharge treatment to have improved adhesion to the image receiving layer (or a cushioning layer if provided as described *infra*) or to improve the adhesion between the image receiving layer and the image forming layer
5 of the heat transfer sheet.

The image receiving sheet has at least one image receiving layer for receiving and holding the image forming layer being transferred from the heat transfer sheet. The image receiving layer is preferably formed of a resin binder matrix. The resin
10 binder is preferably a thermoplastic resin. Examples of suitable thermoplastic resin binders include homopolymers and copolymers of acrylic monomers, e.g., acrylic acid, methacrylic acid, acrylic esters, and methacrylic esters; cellulosic resins, e.g., methyl cellulose, ethyl cellulose, and cellulose
15 acetate,; homopolymers and copolymers of vinyl monomers, e.g., polystyrene, polyvinylpyrrolidone, polyvinyl butyral, polyvinyl alcohol, and polyvinyl chloride; condensed polymers, e.g., polyester and polyamide; and rubbery polymers, e.g., butadiene-styrene copolymers. The binder of the image
20 receiving layer preferably has a T_g of 90°C or lower so as to exhibit moderate adhesion to the image forming layer. A plasticizer may be added to the image forming layer for the purpose of lowering the T_g . The binder resin preferably has a T_g of 30°C or higher for preventing blocking in a roll of
25 the image receiving sheet. It is particularly preferred that

the binder resin of the image receiving layer of the image receiving sheet and that of the image forming layer of the heat transfer sheet be the same or at least analogous to each other so that these layers may be in intimate contact during laser writing thereby to improve transfer sensitivity and image strength.

The image receiving layer surface preferably has a smoother value of 5 mmHg (≈ 0.0665 to 6.65 kPa) or smaller, particularly 1 mmHg or smaller, measured at 23°C and 55% RH, and an Ra of 0.04 to 0.3 μm , particularly 0.05 to 0.2 μm . The surface roughness parameters of the image receiving layer falling within these ranges, the microscopic spaces formed between the image receiving layer and the image forming layer are reduced in size and number, which favors to image transfer and image quality. The static dissipation capability of the image receiving layer is preferably such that, when the layer is electrically charged according to Federal Test Standard Method 4046 and then grounded, the electrification potential 1 second after grounding is -100 to 100 V. It is preferred that the surface resistivity of the image receiving layer at 23°C and 55% RH be $10^9 \Omega$ or less. The image receiving layer preferably has a coefficient of static friction of 0.2 or smaller and a surface energy of 23 to 35 mg/m^2 .

Where the transfer image on the image receiving layer is re-transferred to printing paper, etc., it is preferred that

at least one image receiving layer be made of a photocuring material. A photocuring material includes a combination comprising (a) at least one photopolymerizable monomer selected from polyfunctional vinyl and/or vinylidene compounds capable of addition polymerization, (b) an organic polymer, and (c) a photopolymerization initiator, and optionally (d) additives such as a thermal polymerization inhibitor. The polyfunctional vinyl monomers (a) include unsaturated esters of polyols, particularly acrylic or methacrylic esters (e.g., ethylene glycol diacrylate and pentaerythritol tetraacrylate).

The organic polymer (b) includes those recited above for use to form the image receiving layer. The photopolymerization initiator (c) includes ordinary photo-radical polymerization initiators, e.g., benzophenone and Michler's ketone. The initiator is usually used in an amount of 0.1 to 20% by weight based on the weight of the layer.

The thickness of the image receiving layer is generally from 0.3 to 7 μm , preferably from 0.7 to 4 μm . A thickness of 0.3 μm or larger secures sufficient film strength in re-transferring to printing paper. With a thickness of 4 μm or smaller, glossiness of the image after re-transfer to printing paper is suppressed to improve approximation to final prints.

A cushioning layer that is deformable with a stress imposed to the image receiving layer may be provided between the substrate and the image receiving layer. A cushioning layer

will improve adhesion between the image receiving layer and the image forming layer during laser writing, which leads to image quality improvement. Even when dust enters between the heat transfer sheet and the image receiving sheet, the cushioning layer will be deformed in conformity with the contour of the dust to minimize the non-contact area of the two sheets. As a result, possible image defects, such as white spots, can be minimized in size. Furthermore, when the transfer image on the image receiving sheet is re-transferred to printing paper, etc., the image receiving layer is deformable in conformity with the surface roughness of the paper thereby to improve the transfer capabilities. The cushioning layer is also effective in controlling the glossiness of the re-transfer image and improving approximation to the final prints.

The cushioning layer producing these effects is preferably formed of materials having a low elastic modulus, materials having rubbery elasticity or thermoplastic resins ready to soften on heating. The cushioning layer preferably has an elastic modulus of 0.5 MPa to 1.0 GPa, particularly 1 MPa to 0.5 GPa, especially 10 to 100 MPa, at room temperature. In order for the cushioning layer to have dust or debris sinking, the cushioning layer preferably has a penetration of 10 or more as measured according to JIS K2530 (25°C, 100 g, 5 seconds). The cushioning layer preferably has a T_g of 80°C or lower, particularly 25°C or lower, and a softening point of 50 to 200°C.

To control these physical properties, such as the Tg, a plasticizer may be added to the polymer binder forming the cushioning layer.

Binders making up the cushioning layer include rubbers, such as urethane rubber, butadiene rubber, nitrile rubber, acrylic rubber, and natural rubber, polyethylene, polypropylene, polyester, styrene-butadiene copolymers, ethylene-vinyl acetate copolymer, ethylene-acrylic copolymers, vinyl chloride-vinyl acetate copolymers, vinylidene chloride resins, vinyl chloride resins containing a plasticizer, polyamide resins, and phenol resins. The thickness of the cushioning layer is usually 3 to 100 μm , preferably 10 to 52 μm , while varying depending on the kind of the binder and other conditions.

Although the image receiving layer and the cushioning layer must adhere to each other until completion of laser writing, the image receiving layer is preferably releasable when re-transferring the transfer image onto printing paper. To facilitate the release from the cushioning layer, a release layer having a thickness of about 0.1 to 2 μm can be provided between the cushioning layer and the image receiving layer. The thickness of the release layer, which can be adjusted by proper choice of material, should be small so as not to impair the effects of the cushioning layer.

Binders used to form the release layer include

thermoplastic resins having a Tg of 65°C or higher, such as polyolefins, polyester, polyvinyl acetal, polyvinyl formal, polyparabanic acid, polymethyl methacrylate, polycarbonate, ethyl cellulose, nitrocellulose, methyl cellulose, 5 carboxymethyl cellulose, hydroxypropyl cellulose, polyvinyl alcohol, polyvinyl chloride, urethane resins, fluorine resins, polystyrene, acrylonitrile-styrene copolymers, crosslinking products of these resins, polyamide, polyimide, polyether-imide, polysulfone, polyether sulfone, and aramid; 10 and hardened products thereof. Commonly employed hardening agents, such as isocyanate and melamine, can be used for hardening.

The physical properties described above taken into consideration, binders preferred for making the release layer 15 are polycarbonate, acetal resins, and ethyl cellulose for their good storage stability. These binders are particularly suitable for releasing the image receiving layer containing an acrylic resin binder.

A layer that extremely reduces in adhesion to the image 20 receiving layer on cooling can serve as a release layer. Such a layer comprises hot-melt compounds including waxes and binders and thermoplastic resins as a main ingredient. Useful hot-melt compounds are described in JP-A-63-193886. Preferred hot-melt compounds include microcrystalline wax, paraffin wax, and 25 carnauba wax. Useful thermoplastic resins include ethylene

copolymers, such as ethylene-vinyl acetate copolymers, and cellulosic resins.

If desired, the above-described release layers can contain such additives as higher fatty acids, higher alcohols, 5 higher fatty acid esters, higher fatty acid amides, and higher aliphatic amines.

A layer that melts or softens on heating and undergoes cohesive failure also serves as a release layer. A supercooling material is preferably incorporated into a release layer of 10 this kind. Useful supercooling materials include poly-ε-caprolactone, polyoxyethylene, benzotriazole, tribenzylamine, and vanillin.

A layer containing a compound which reduces the adhesion to the image receiving layer is also useful as a release layer. 15 Such compounds include silicone resins, e.g., silicone oil; fluorine resins, e.g., Teflon and fluorine-containing acrylic resins; polysiloxane resins; acetal resins, e.g., polyvinyl butyral, polyvinyl acetal, and polyvinyl formal; solid waxes, e.g., polyethylene wax and amide wax; and fluorine type or 20 phosphoric ester type surface active agents.

The release layer is formed by applying a solution or an emulsion (latex) of the above-mentioned material in a solvent to the cushioning layer by various techniques, such as blade coating, roll coating, bar coating, curtain coating, gravure 25 coating, hot-melt extrusion lamination, and the like.

Alternatively, the solution or latex may be applied to a carrier film by the above-described application techniques to form a coating film, which is transferred to the cushioning layer.

In an embodiment of the image receiving sheet structure, the image receiving layer may serve as a cushioning layer. In this embodiment, the image receiving sheet may have a layer structure of substrate/cushioning image receiving layer or a layer structure of substrate/undercoating layer/cushioning image receiving layer. In this embodiment, too, it is preferred for the cushioning image receiving layer be provided such that it is ready to be released and transferred to printing paper. In this case, the re-transfer image will have excellent gloss. The cushioning image receiving layer usually has a thickness of 5 to 100 μm , preferably 10 to 40 μm .

It is advisable to provide a backcoating layer on the reverse side (opposite to the image receiving layer side) of the substrate to improve transport properties of the image receiving sheet in a recording apparatus. The improvement on film transport properties is ensured by adding to the backcoating layer an antistatic agent (e.g., a surface active agent or tin oxide particles) and/or a matting agent (e.g., silicon oxide or polymethyl methacrylate particles). According to necessity, these additives may be added to not only the backcoating layer but other layers including the image receiving layer. The kind of the additive to be added depends on the purpose. Where,

for example, a matting agent is needed, a matting agent having an average particle size of 0.5 to 10 μm is added in an amount of about 0.5 to 80% by weight based on the layer to which it is added. Where an antistatic agent is needed, an appropriate
5 compound selected from various surface active agents and electrically conductive agents is added to reduce the surface resistivity of the layer to $10^{12} \Omega$ or lower, preferably $10^9 \Omega$ or less, at 23°C and 50% RH.

General-purpose polymers can be used as a binder of the
10 backcoating layer, including gelatin, polyvinyl alcohol, methyl cellulose, nitrocellulose, cellulose acetate, aromatic polyamide resins, silicone resins, epoxy resins, alkyd resins, phenol resins, melamine resins, fluorine resins, polyimide resins, urethane resins, acrylic resins, urethane-modified
15 silicone resins, polyethylene resins, polypropylene resins, polyester resins, Teflon resins, polyvinyl butyral resins, vinyl chloride resins, polyvinyl acetate, polycarbonate, organoboron compounds, aromatic esters, polyurethane fluoride, and polyether sulfone. Among them crosslinkable water-soluble
20 resins can be crosslinked to become a binder effective in preventing fall-off of matting agent particles, improving scratch resistance of the backcoating layer, and preventing blocking of image receiving sheets during storage. The crosslinking of the crosslinkable water-soluble resins can be
25 induced by any at least one of heat, active light rays, and

pressure. In some cases, an arbitrary adhesive layer may be provided between the substrate and the backcoating layer.

Organic or inorganic fine particles can be used as a matting agent added to the backcoating layer. Organic matting agents include particles of polymers obtained by radical polymerization, such as polymethyl methacrylate, polystyrene, polyethylene, and polypropylene; and condensed polymers, such as polyester and polycarbonate.

The backcoating layer preferably has a coating weight of about 0.5 to 5 g/m². A coating film thinner than 0.5 g/m² is difficult to form stably and tends to allow matting agent particles to fall off. If the coating thickness exceeds 5 g/m², the matting agent present therein must have a considerably large particle size to exhibit its effect. Such large particles in the backcoating layer will imprint themselves on an adjacent image receiving layer in a roll form. It would follow that the transfer image on the image receiving layer may suffer from image deficiency or unevenness on account of the imprinted surface unevenness particularly where the image forming layer is very thin.

It is preferred for the matting agent used in the backcoating layer to have a number-averaged particle size greater than the thickness of the particle-free area of the backcoating layer by 2.5 to 20 μ m. It is necessary that matting agent particles of 8 μ m or greater be present in the backcoating

layer in an amount of 5 mg/m² or more, particularly 6 to 600 mg/m², thereby to reduce troubles due to foreign matter. In order to prevent image defects attributed to extraordinary large particles and to obtain desired performance with a reduced amount of a matting agent, it is preferred to use a matting agent whose sizes are narrowly distributed with a coefficient of variation σ/\bar{r}_n (obtained by dividing a standard deviation of a distribution by a mean) of 0.3 or smaller, preferably 0.15 or smaller.

The backcoating layer preferably contains an antistatic agent to prevent foreign matter attraction due to triboelectricity. A wide range of known antistatic agents can be used, such as cationic, anionic or nonionic surface active agents, polymeric antistatics, electrically conductive particles, and those described in *11290 no Kagaku Syohin*, Kagaku Kogyo Nipposha, 875-876. Of these antistatic agents preferred for use in the backcoating layer are electrically conductive materials, such as carbon black, metal oxides, e.g., zinc oxide, titanium oxide, and tin oxide, and organic semiconductors. Electrically conductive fine particles are particularly preferred, for they do not separate from the backcoating layer to exert stable and environment-independent antistatic effects.

The backcoating layer can further contain various activators or release agents, such as silicone oil and fluorine resins, for improving coating capabilities or releasability.

It is especially advisable to provide the above-described backcoating layer where the cushioning layer and the image receiving layer have a softening point of 70°C or lower measured by thermochemical analysis (hereinafter referred to as a TMA softening point). The TMA softening point is obtained by observing the phase of a sample being heated at a given rate of temperature rise with a given load applied thereto. In the present invention, the temperature at which the phase of the sample begins to change is defined as a TMA softening point. Measurement of a TMA softening point can be made with, for example, Thermoflex supplied by Rigaku Denki-Sha.

In carrying out thermal transfer recording, the heat transfer sheet and the image receiving sheet are superposed on each other to prepare a laminate with the image forming layer of the former and the image receiving layer of the latter in contact.

A laminate of the heat transfer sheet and the image receiving sheet can be prepared through various methods. For example, the two sheets superposed on each other in the above-described manner are passed through a pair of pressure and heat rollers. The heating temperature of the rollers is 160°C or lower, preferably 130°C or lower.

Another method of preparing the laminate is vacuum holding, which has previously been described with respect to the recording apparatus. That is, the image receiving sheet is the first

to be held by suction around a recording drum having a number of suction holes. The heat transfer sheet, which is designed to be slightly larger in size than the image receiving sheet, is then held on the image receiving sheet while the entrapped air is pressed out with a squeeze roller. Still another method of preparing the laminate comprises pulling the image receiving sheet to a recording drum, mechanically fixing the sheet onto the drum, and then fixing the heat transfer sheet thereon in the same manner as for the image receiving sheet. The vacuum holding method is especially advantageous in that temperature control (as required for heat rollers) is unnecessary, and uniform contact of the two sheets is accomplished quickly.

15 EXAMPLES

The present invention will now be illustrated in greater detail with reference to Examples, but it should be understood that the invention is not deemed to be limited thereto. Unless
20 otherwise noted, all the parts and percents are by weight.

EXAMPLE 1

1. Preparation of heat transfer sheet (A)

1-1. Formation of backcoating layer

A coating composition for 1st backing layer was prepared
25 from the following components.

	Aqueous dispersion of acrylic resin (Jurymer ET410, available from Nihon Junyaku Co., Ltd.; solid content: 20%)	2 parts
5	Antistatic agent (water-born dispersion of tin oxide-antimony oxide; average particle size: 0.1 μm ; solids content: 17%)	7.0 parts
	Polyoxyethylene phenyl ether	0.1 part
	Melamine compound (Sumitex Resin M-3, from Sumitomo Chemical Co., Ltd.)	0.3 part
10	Distilled water	to make 100 parts

Abiaxially stretched polyethylene terephthalate (PETP) film having a thickness of 75 μm and an Ra of 0.01 μm on both sides was subjected to corona discharge treatment on one side. The coating composition for 1st backcoating layer was applied to the corona discharge treated side of the substrate to a dry thickness of 0.03 μm and dried at 180°C for 30 seconds to form a first backcoating layer. The substrate used had a Young's modulus of 450 kg/mm² (\approx 4.4 GPa) in the MD and of 500 kg/mm² (\approx 4.9 GPa) in the TD; an F-5 value of 10 kg/mm² (\approx 98 MPa) in the MD and of 13 kg/mm² (\approx 127.4 MPa) in the TD; a thermal shrinkage percentage of 0.3% in the MD and of 0.1% in the TD both after heating at 100°C for 30 minutes; a breaking strength of 20 kg/mm² (\approx 196 MPa) in the MD and of 25 kg/mm² (\approx 245 MPa) in the TD; and an elastic modulus of 400 kg/mm² (\approx 3.9 GPa).

25 A coating composition for 2nd backcoating layer was

prepared from the following components.

	Polyolefin (Chemipearl S-120, available from Mitsui Chemicals, Inc.; solid content: 27%)	3.0 parts
5	Antistatic agent (water-born dispersion of tin oxide-antimony oxide; average particle size: 0.1 μ m; solids content: 17%)	2.0 parts
	Colloidal silica (Snowtex C, available from Nissan Chemical Industries, Ltd.; solid content: 20%)	2.0 parts
10	Epoxy compound (Denacol EX-614B, from Nagase Chemical Co., Ltd.)	0.3 part
	Distilled water	To make 100 parts

The coating composition for 2nd backcoating layer was applied to the first backcoating layer to a dry thickness of 0.03 μ m and dried at 170°C for 30 seconds to form a second backcoating layer.

1-2. Formation of light-heat conversion layer

The components shown below were mixed with agitation in a stirrer to prepare a coating composition for light-heat conversion layer.

	Infrared absorbing dye (compound I-2)	10 parts
	Binder (polyamide-imide resin shown in Table 1)	200 parts
	N-Methyl-2-pyrrolidone	2000 parts
25	Methyl ethyl ketone (MEK)	360 parts

Surface active agent (Magafac F-177, from Dainippon Ink
& Chemicals, Inc.) 1 part

Matting agent dispersion 14.1 parts

The matting agent dispersion was prepared as follows.

5 A mixture of 10 parts of true spherical silica powder having
an average particle size of 1.5 μm (Seahostar KE-P150, from
Nippon Shokubai Co., Ltd.), 2 parts of an acrylic ester-styrene
copolymer as a dispersant (Joncryl 611, from Johnson Polymer
Co., Ltd.), 16 parts of MEK, and 64 parts of N-methylpyrrolidone
10 was put in a 200 ml polyethylene container together with 30
parts of glass beads having a diameter of 2 mm. The mixture
in the container was dispersed in a paint shaker supplied by
Toyo Seiki Co., Ltd. for 2 hours to prepare a matting agent
dispersion.

15 The resulting coating composition was applied to a side
of a 100 μm thick PETP film having a center-line average
roughness R_a of 0.04 μm (available from Toray Industries, Inc.)
with a whirler and dried in an oven at 120°C for 2 minutes to
form a light-heat conversion layer. The light-heat conversion
20 layer had an absorption maximum at around 808 nm within the
region of from 700 to 1000 nm. The absorbance (optical density;
OD) at the absorption maximum wavelength was 1.0. A cut area
of the light-heat conversion layer was observed under a scanning
electron microscope (SEM) to find that the average layer
25 thickness was 0.3 μm .

1-3. Formation of image forming layer (A)

A coating composition for image forming layer (A) was prepared as follows.

Formulation 1:

5	Polyvinyl butyral (Denka Butyral #2000-L, available from Denki Kagaku Kogyo KK; Vicat softening point: 57°C)	65 parts
10	Mica pigment (Iriodin 123, titanium dioxide-coated pearl pigment available from Merck Japan Ltd.; particle size: 5 to 25 μm ; particle thickness: 0.2 to 0.5 μm)	30 parts
	Dispersant (Disparlon #1831, polycarboxylic acid-long chain amine salt polymer available from Kusumoto Chemicals Ltd.)	0.4 parts
15	Thixotropic agent (Disparlon 6900-20X, fatty acid amide available from Kusumoto Chemicals Ltd.; solid content: 20%)	9 parts
	Thixotropic agent (Disparlon 4200-10, polyethylene oxide available from Kusumoto Chemicals Ltd.; solid content: 10%)	26 parts
20	n-Propyl alcohol (solvent)	550 parts

The binder, the thixotropic agents, and the dispersant were dissolved in part of the solvent with agitation. The mica pigment was added to the solution and dispersed in an ultrasonic disperser. The dispersion was diluted with the rest of the

solvent to prepare a composition 1.

The components shown below were mixed while agitation with a stirrer to prepare a coating composition for image forming layer (A).

5 Formulation 2:

	Composition 1 (prepared above)	185.7 parts
	Polyvinyl butyral (S-LEC B BL-SH, available from Sekisui Chemical Co., Ltd.)	11.9 parts
	Stearic acid (wax)	10 parts
10	Rosin (KE-311, available from Arawaka Chemical Industries, Ltd.; resin acid content: 80 to 97% (composed of abietic acid 30 to 40%, neoabietic acid 10 to 20%, dihydroabietic acid 14%, and tetrahydroabietic acid 14%))	11.4 parts
	Surface active agent (Megafac F-176PF, available from Dainippon Ink & Chemicals, Inc.; solid content: 20%)	2.1 parts
	Inorganic pigment (MEK-ST, 30% solution in MEK, available from Nissan Chemical Industries, Ltd.)	7.1 parts
	n-Propyl alcohol	1050 parts
20	MEK	295 parts

The particle size distribution in the resulting coating composition was measured with a laser scattering particle size distribution analyzer. As a result, the average particle size was 0.25 μm , and the proportion of particles of 1 μm or greater was 0.5%.

25

The coating composition for image forming layer (A) was applied to the light-heat conversion layer by means of a whirler for 1 minute and dried in an oven at 100°C for 2 minutes to prepare a heat transfer sheet (A) having an image forming layer (A).

A cut area of the image forming layer (A) was observed under an SEM to find that the average layer thickness was 0.7 μm and that the mica pigment particles were oriented with their main planes substantially in parallel with the substrate plane. The image forming layer (A) had a silver hue and a gloss of 2.7 in terms of L^*_{25}/L^*_{75} as measured according to the previously described method.

2. Preparation of heat transfer sheets (B)

A coating composition for yellow heat transfer sheet (B) was prepared as follows.

Formulation 1:

Polyvinyl butyral (Denka Butyral #2000-L, available from Denki Kagaku Kogyo KK; Vicat softening point: 57°C)

12 parts

Yellow pigment (C.I. Pigment Yellow 14)

12 parts

Dispersant (Solsperse S-20000, available from ICI)

0.8 part

n-Propyl alcohol

110 parts

The components of formulation 1 were dispersed with 100 g of glass beads for 2 hours by means of a paint shaker to prepare

a yellow pigment master batch. The following components were mixed while agitating with a stirrer to prepare a coating composition for a yellow image forming layer (B).

Formulation 2:

5	Yellow pigment master batch	20 parts
	n-Propyl alcohol	60 parts
	Stearamide	0.5 part
	Surface active agent (Megafac F-176PF, available from Dainippon Ink & Chemicals, Inc.)	0.05 part

10

Coating compositions for magenta, cyan and black image forming layers (B) were prepared in the same manner as for the coating composition for yellow image forming layer (B), except for replacing the yellow pigment with C.I. Pigment Red 57:1, 15 C.I. Pigment Blue 15:4, and carbon black (MA-100, available from Mitsubishi Chemical Corp.), respectively.

Yellow, magenta, cyan, and black heat transfer sheets (B) were prepared in the same manner as for the heat transfer sheet (A), except for using the above-prepared coating 20 compositions.

The heat transfer sheets A and B had a center-line average roughness Ra of 0.08 μm . The image receiving sheet prepared as described below had an Ra of 0.13 μm and a smoother value of 0.7 mmHg or less. The Ra measurement was made with a 25 profilometer supplied by Toyo Seiki Co., Ltd. under conditions

of an MD magnification of 2000 times, a cut-off length of 0.08 mm, an assessment length of 2.50 mm, and a measurement speed of 0.1 mm/sec. The smoofter value measurement was made with an instrument for measuring air permeability and smoothness
5 (DIGITAL SMOOSTER, supplied by Toei Denshi Kogyo K.K.).

3. Preparation of image receiving sheet

A coating composition for cushioning layer and a coating composition for image receiving layer were prepared according to the following formulations.

10 Formulation of cushioning layer:

	Vinyl chloride-vinyl acetate copolymer as a main binder (MPR-TSL, available from Nisshin Chemical Industry Co., Ltd.)	20 parts
	Plasticizer (Paraplex G-40, available from The C.P. Hall Co.)	10 parts
15	Fluorine-type surface active agent as a coating aid (Megafac F-177, available from Dainippon Ink & Chemicals, Inc.)	0.5 part
20	Antistatic agent (SAT-5 Supper (IC), quaternary ammonium salt available from Nihon Jynyaku Co., Ltd.)	0.3 part
	MEK	60 parts
	Toluene	10 parts
	N,N-Dimethylformamide	3 parts

25

Formulation of image receiving layer:

	Polyvinyl butyral (S-LEC B BL-SH, available from Sekisui Chemical Co., Ltd.)	8.0 parts
	Antistatic agent (Sanstat 2012A, available from Sanyo Chemical Industries, Ltd.)	0.7 parts
5	Surface active agent (Megafac F-177, from Dainippon Ink & Chemicals, Inc.)	0.1 part
	n-Propyl alcohol	20 parts
	Methanol	20 parts
10	1-Methoxy-2-propanol	50 parts

The coating composition for cushioning layer was applied to a white PETP film having a thickness of 135 μm (Lumirror E-68L, available from Toray Industries, Inc.) with a small-width applicator to a dry thickness of about 20 μm and dried to form a cushioning layer. The coating composition for an image receiving layer was applied thereon to a dry thickness of about 2 μm and dried to form an image receiving layer.

Each of the resulting heat transfer elements was wound into a roll and stored at room temperature for one week for evaluation.

The heat transfer sheets and the image receiving sheet both had a surface waviness of 2 μm or smaller as measured with a profilometer under conditions of an MD magnification of 2000 times, a cut-off length of 0.08 mm, an assessment length of

5 mm, and a measurement speed of 0.15 mm/sec. In all the Examples hereinafter described the same results of waviness were obtained.

5 4. Laser recording and transfer

The image receiving sheet (25 cm wide, 35 cm long) was held around a recording drum (diameter: 25 cm) by suction through suction holes of 1 mm in diameter of the drum (one hole per 3 cm by 3 cm area). The black heat transfer sheet (B) (30 cm
10 wide, 40 cm long) was then superposed on the image receiving sheet with its four edges extending evenly from the edges of the image receiving sheet while being squeezed with a squeeze roller so that the two sheets were brought into intimate contact while allowing entrapped air to escape and be sucked. The degree
15 of vacuum of the drum, measured with the suction holes closed, was atmospheric pressure minus 150 mmHg. The drum was rotated, and the heat transfer sheet was scanned with semiconductor laser light having a wavelength of 808 nm (a multi-mode semiconductor laser; rated output power: 1 W) and modulated according to image
20 data, the laser being moving in a direction (slow scan direction) perpendicular to the drum rotating direction (fast scan direction), under the following conditions to carry out laser image recording.

Laser power: 300 mW

25 Beam spot diameter: 15 μ m (Gaussian distribution) in the fast

scan direction; 24 μm in the slow scan direction

Fast scanning speed: 5 m/sec

Slow scanning pitch: 30 μm

Environment: 25°C, 50% RH

5

After completion of recording, the heat transfer sheet (B) was removed by hand with the image receiving sheet held to the drum, whereby a black image was transferred to the image receiving sheet. A yellow image and a luster pigment image were successively transferred onto the black image in this order using the yellow heat transfer sheet (B) and the heat transfer sheet (A), respectively, in the same manner as described above.

5. Re-transfer of recorded image

15 The image receiving sheet having a transfer image was superposed on art paper (high quality coated paper). The two sheets were passed through a pair of heat rollers at 130°C under a pressure of 4.5 kg/cm² at a speed of 4 m/sec. The white PETP film of the image receiving sheet was stripped off the laminate, leaving the image receiving layer and the transfer image on the paper.

The image area with a high metallic luster of the resulting re-transferred image was composed of a gold image area and a silver image area, each of which was observed with a magnifier.

25 The area with a gold luster was found to be a superimposition

of a solid (100%) silver image, a yellow dot image, and a black dot image on the paper in the order described. The area with a silver luster was a solid (100%) silver image with no yellow nor black dots superimposed.

5

EXAMPLE 2

Heat transfer sheets and an image receiving sheet were prepared in the same manner as in Example 1, except for replacing the mica pigment (Iriodin 123; particle size: 5 to 25 μm) with synthetic mica (Micromica MK-100, available from Co-op Chemical Co., Ltd.). The thickness, gloss, Ra, surface waviness, and smoothening value of the image forming layer (A) were 0.7 μm , 1.8, 0.07 μm , 2 μm , and 1 mmHg, respectively. Laser thermal transfer recording was carried out using these transfer elements in the same manner as in Example 1 to obtain a glossy, high quality image.

EXAMPLE 3

Heat transfer sheets and an image receiving sheet were prepared in the same manner as in Example 1, except for replacing the mica pigment (Iriodin 123) with a pearl pigment comprising bismuth oxychloride (Biron, available from Merck Japan Ltd.). The thickness, gloss, Ra, surface waviness, and smoothening value of the image forming layer (A) were 0.7 μm , 2.2, 0.1 μm , 2 μm , and 1 mmHg, respectively. Laser thermal transfer recording

was carried out using these transfer elements in the same manner as in Example 1 to obtain a glossy, high quality image.

EXAMPLE 4

5 Heat transfer sheets and an image receiving sheet were prepared in the same manner as in Example 1, except for replacing the coating composition for image forming layer (A) used in Example 1 with a coating composition having the following formulation. The thickness, gloss, Ra, surface waviness, and
10 smoother value of the image forming layer (A) were 0.8 μm , 2.3, 0.11 μm , 2 μm , and 1 mmHg, respectively.

Coating composition for image forming layer (A):

	Polyvinyl butyral (Denka Butyral #2000-L, available from	
15	Denki Kagaku Kogyo KK; Vicat softening point: 57°C)	
		65 parts
	Mica pigment (Iriodin 323, iron oxide-coated pearl pigment available from Merck Japan Ltd.; particle size: 5 to 25 μm ; particle thickness: 0.2 to 0.5 μm)	
20		30 parts
	Pigment for hue control (carbon black MA-100, available from Mitsubishi Chemical Corp.)	0.65 part
	Dispersant (Disparlon #1831, polycarboxylic acid-long chain amine salt polymer available from Kusumoto	
25	Chemicals Ltd.)	0.4 part

Thixotropic agent (Disparlon 6900-20X, fatty acid amide
available from Kusumoto Chemicals Ltd.; solid content:
20%) 9 parts

5 Thixotropic agent (Disparlon 4200-10, polyethyleneoxide
available from Kusumoto Chemicals Ltd.; solid content:
10%) 26 parts

n-Propyl alcohol 550 parts

Laser thermal transfer recording was carried out using
10 these transfer elements in the same manner as in Example 1 to
obtain a high quality image with gold luster. The transfer
image was re-transferred to art paper in the same manner as
in Example 1. The re-transferred image on the art paper was
highly glossy with gold luster. Observed with a magnifier,
15 the image area with gold luster was found to be a superimposition
of a solid silver image, a yellow dot image, and a black dot
image on the paper in the order described.

EXAMPLE 5

20 Heat transfer sheets and an image receiving sheet were
prepared in the same manner as in Example 1, except for replacing
the coating composition for image forming layer (A) used in
Example 1 with a coating composition having the following
formulation. The gloss, Ra, surface waviness, and smoother
25 value of the image forming layer (A) were 2.2, 0.08 μm , 2 μm ,

and 1 mmHg, respectively.

Coating composition for image forming layer (A):

5	Polyvinyl butyral as binder (Denka Butyral #2000-L, available from Denki Kagaku Kogyo KK; Vicat softening point: 57°C)	52 parts
	Acrylic resin as binder (BR-88, available from Mitsubishi Rayon Co., Ltd.)	13 parts
10	Mica pigment (Iriodin 323, iron oxide-coated pearl pigment available from Merck Japan Ltd.; particle size: 5 to 25 µm; particle thickness: 0.2 to 0.5 µm)	30 parts
15	Dispersant (Disparlon #1831, polycarboxylic acid-long chain amine salt polymer available from Kusumoto Chemicals Ltd.)	0.4 parts
	Thixotropic agent (Disparlon 6900-20X, fatty acid amide available from Kusumoto Chemicals Ltd.; solid content: 20%)	9 parts
20	Thixotropic agent (Disparlon 4200-10, polyethylene oxide available from Kusumoto Chemicals Ltd.; solid content: 10%)	26 parts
	n-Propyl alcohol	550 parts
25	Laser thermal transfer recording was carried out using	

these transfer elements in the same manner as in Example 1. The transfer image was re-transferred to art paper in the same manner as in Example 1. The re-transferred image on the art paper was composed of a gold luster image area and an ordinary color image area. Observed with a magnifier, the image area with gold luster was found to be a superimposition of a solid silver image, a yellow dot image, and a black dot image on the paper in the order described, which looked like gold.

COMPARATIVE EXAMPLE 1

Laser thermal transfer recording was carried out in the same manner as in Example 1, except for making alterations to the additives used in the image forming layer (A) as shown in Table 1.

The heat transfer sheets prepared in Examples 1 to 5 and Comparative Example 1 were evaluated for sensitivity and resolution in application to the above-described system configuration as follows. The results obtained are shown in Table 1.

a) Sensitivity

Laser recording was carried out at a fast scanning speed varying from 1 to 10 m/sec. The scanning speed at which 100 μ m square dots were reproduced with sharp edges was taken as a measure of sensitivity. A higher value means higher sensitivity. A speed of 3 m/sec or higher indicates satisfactory performance.

b) Resolution

The least width (μm) of lines reproduced at a fast scanning speed of 5 m/sec is taken as a resolution. A smaller value means a higher resolution.

5

TABLE 1

	Light-heat Conversion Layer		Image Forming Layer A		Sensitivity (m/sec)	Resolution (μm)
	IR Absorbing Dye	R of Binder (I)	Luster Pigment* ¹	Thixotropic Agent		
Example 1	I-2	(6)	Iriodin 123	Disparlon 6900-20X* ² + Disparlon 4200-10* ³	5	100
Example 2	"	"	synthetic mica	"	6	20
Example 3	"	"	Biron	"	5	100
Example 4	"	"	Iriodin 323	"	5	100
Example 5	"	"	"	"	4	100
Compa. Example 1	"	"	"	none	unmeasurable	

Note:

*1: Tabular inorganic compound particles

*2: Fatty acid amide

*3: Polyethylene oxide

10

The image forming method according to the present invention provides a high quality multicolor image with excellent metallic luster at high sensitivity. The method is

useful to create a color proof (DDCP) in DTP work or a mask image.

This application is based on Japanese Patent application
5 JP 2002-184871, filed June 25, 2002, the entire content of which
is hereby incorporated by reference, the same as if set forth
at length.